

FIG. 1

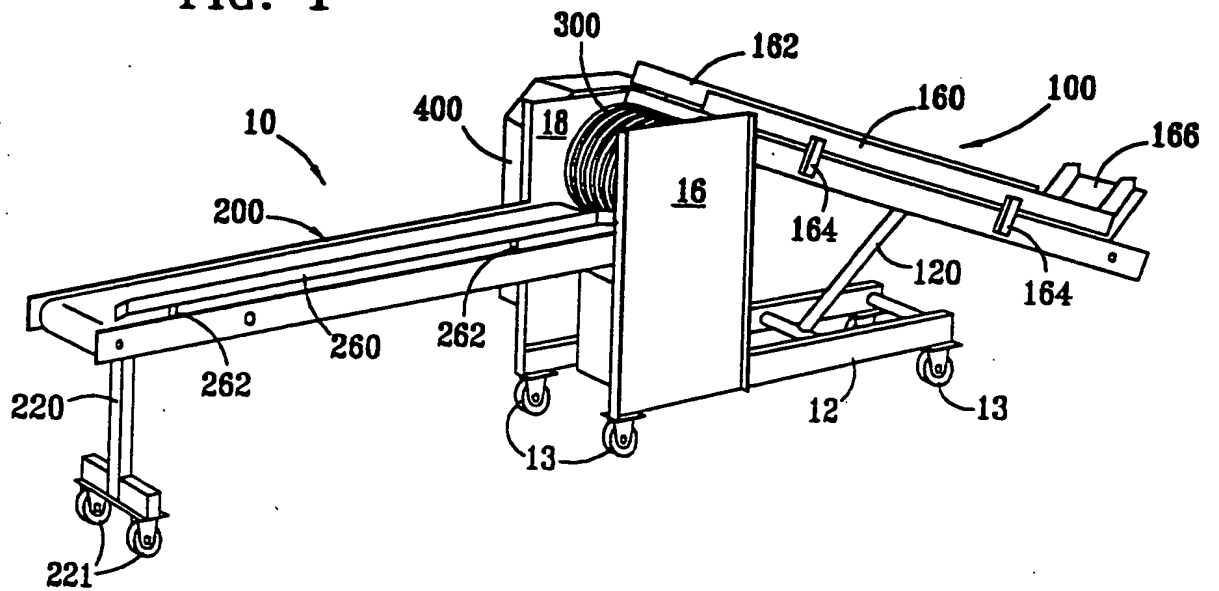


FIG. 2

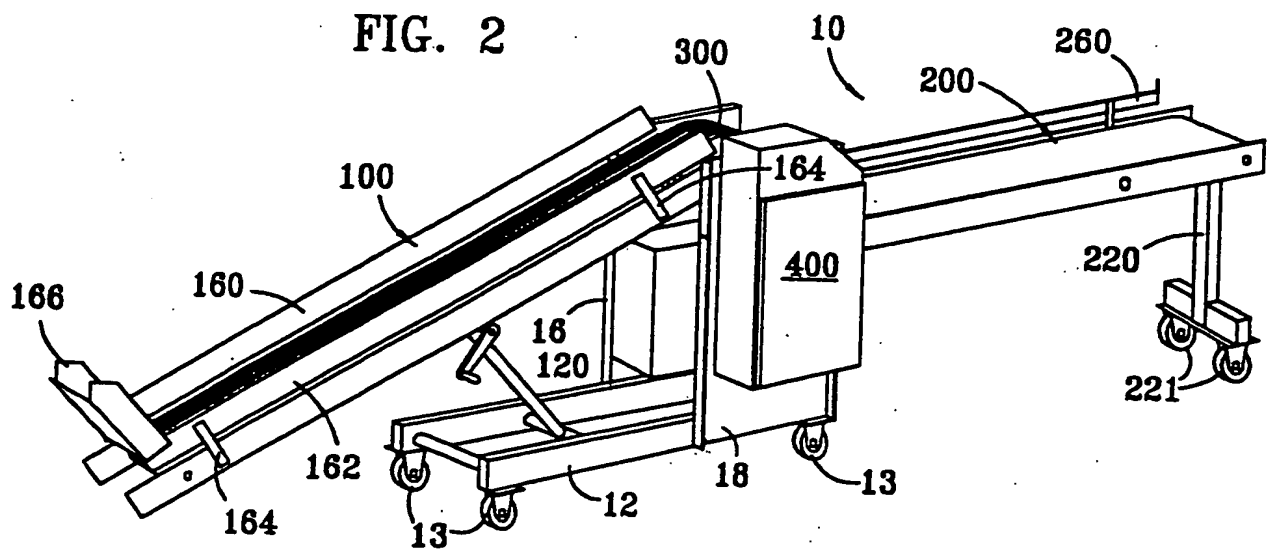


FIG. 3

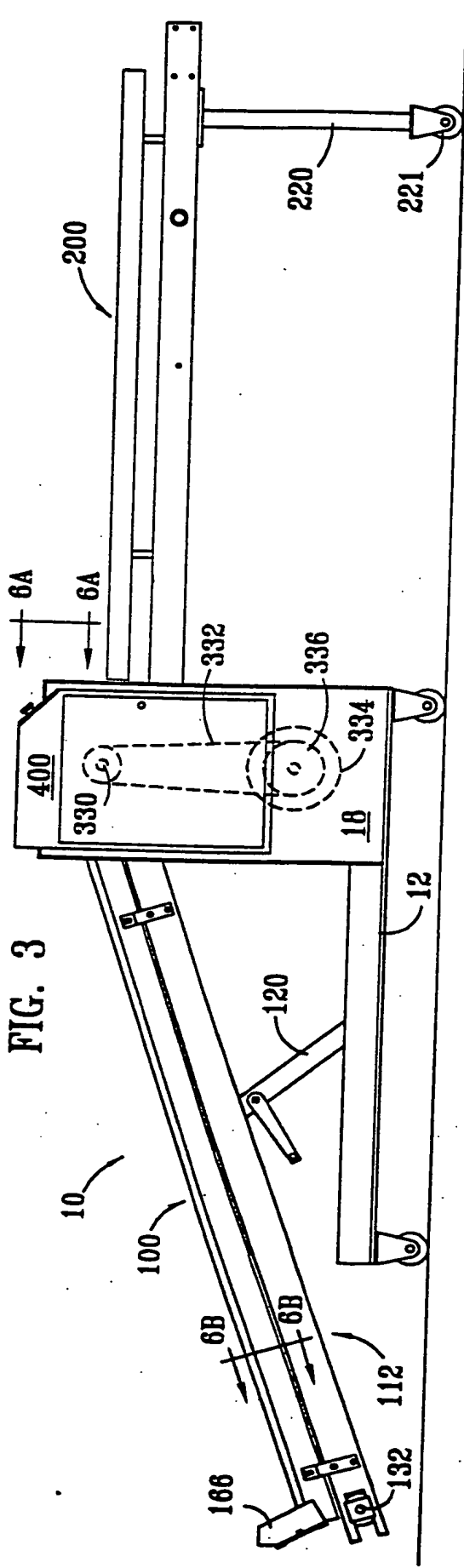


FIG. 6A

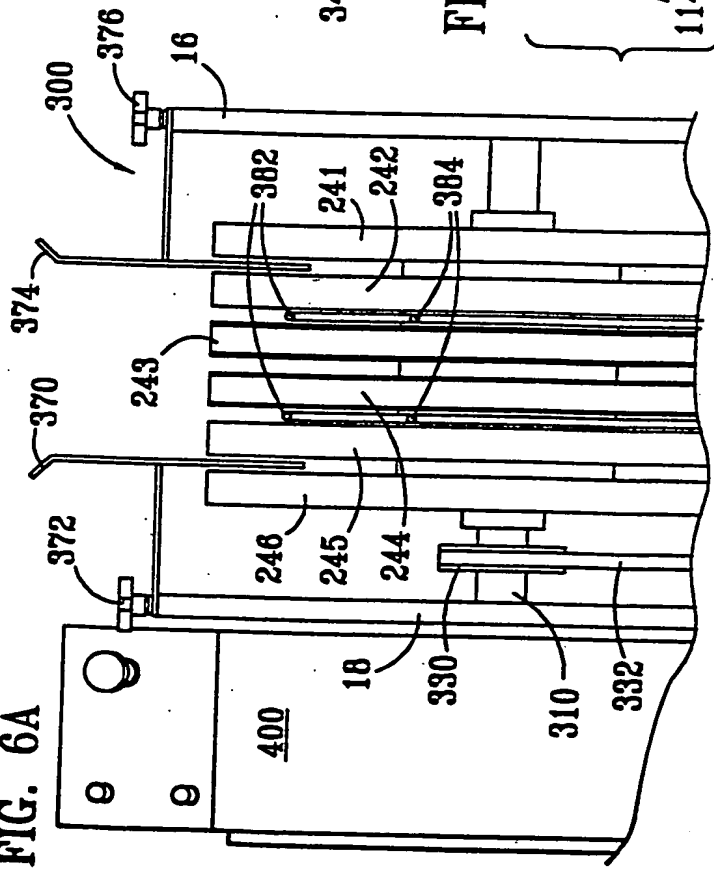


FIG. 7A

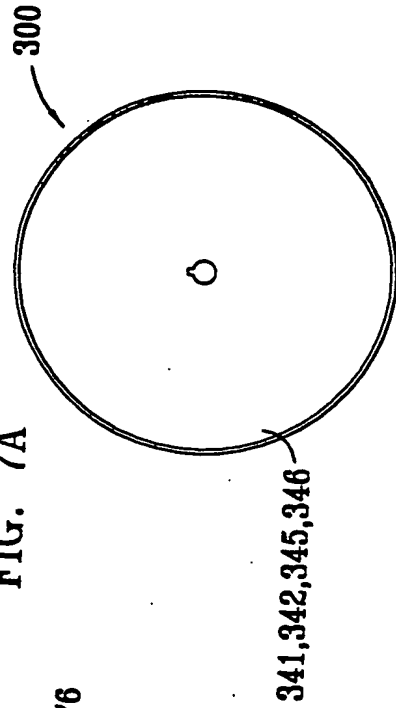


FIG. 7B
144, 142, 145, 146

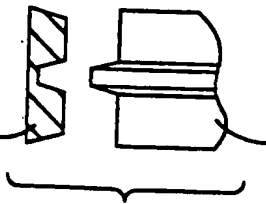


FIG. 6B

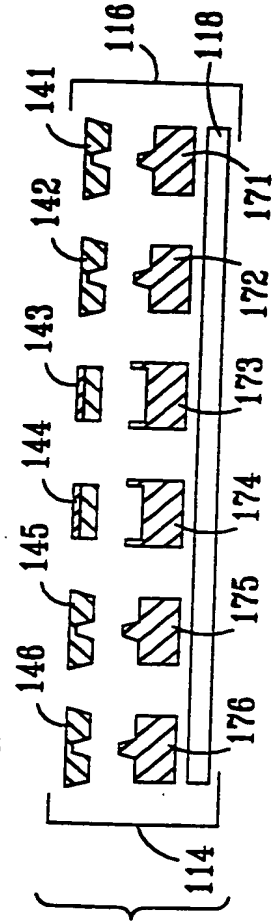


FIG. 4

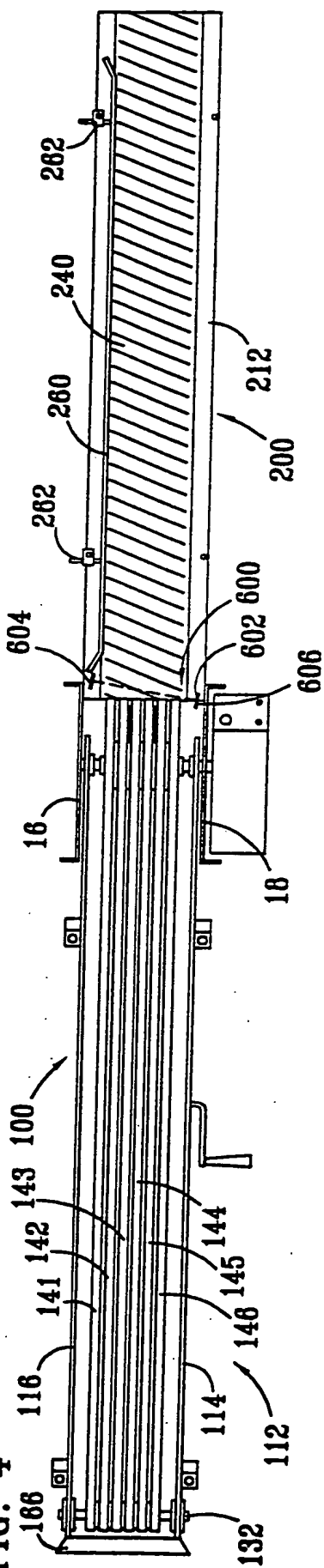
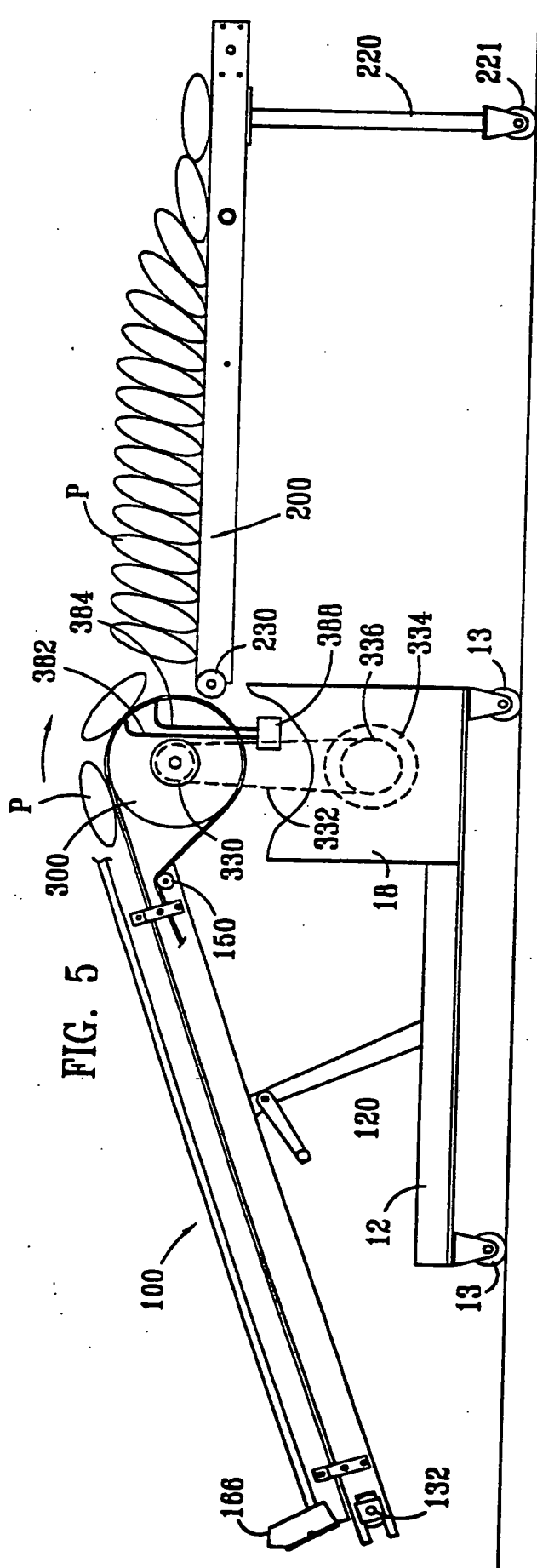


FIG. 5



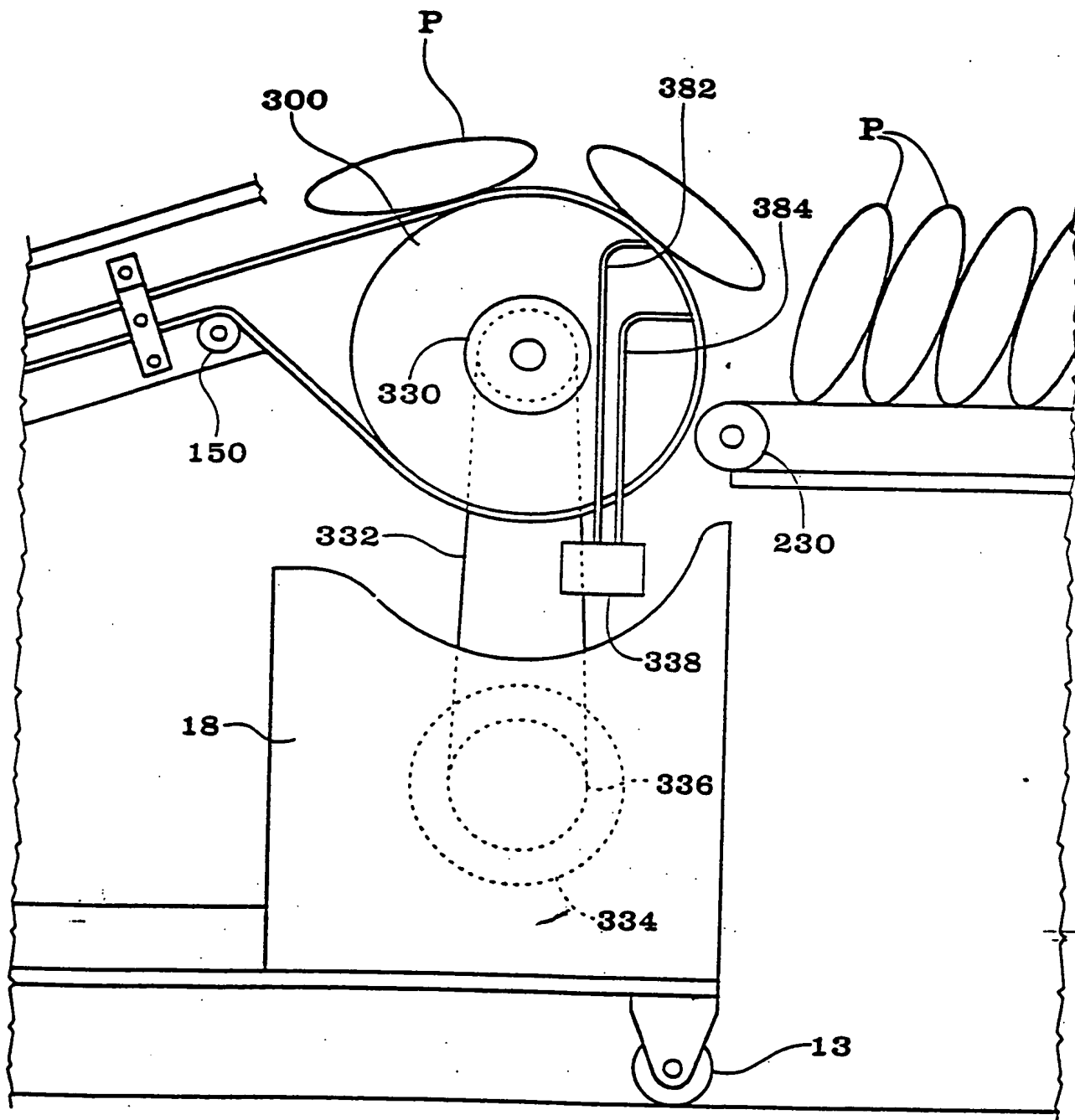


FIG.5A

FIG. 7C

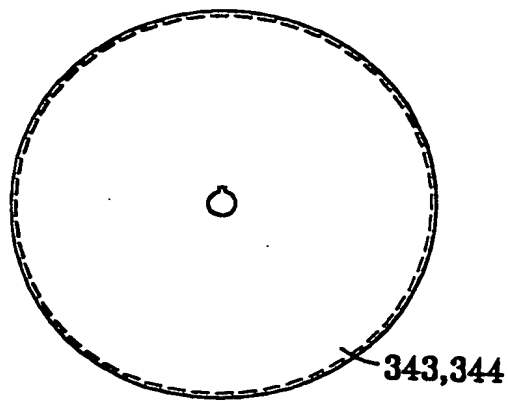


FIG. 7D

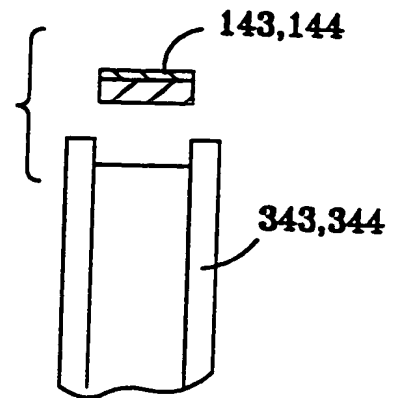


FIG. 8A

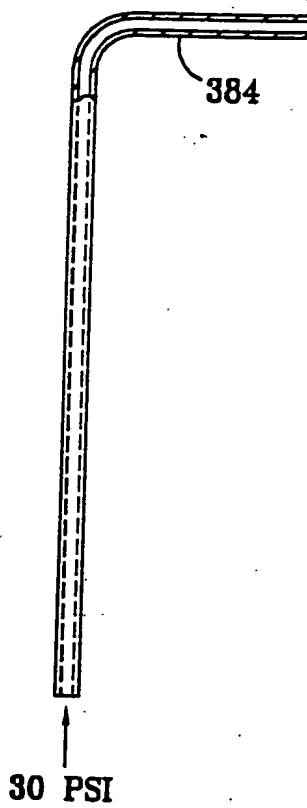


FIG. 8B

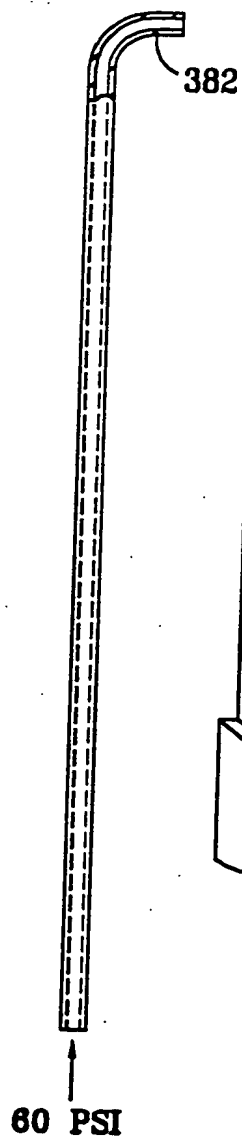


FIG. 9

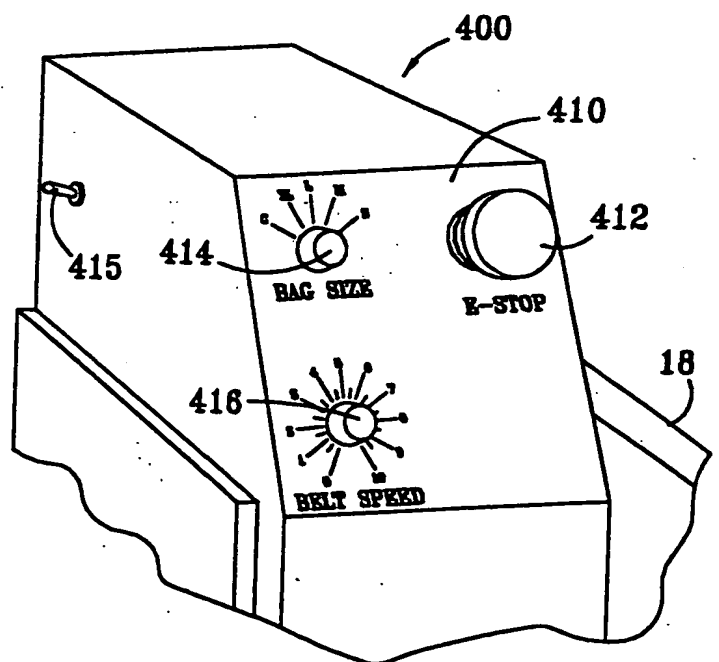


FIG. 10

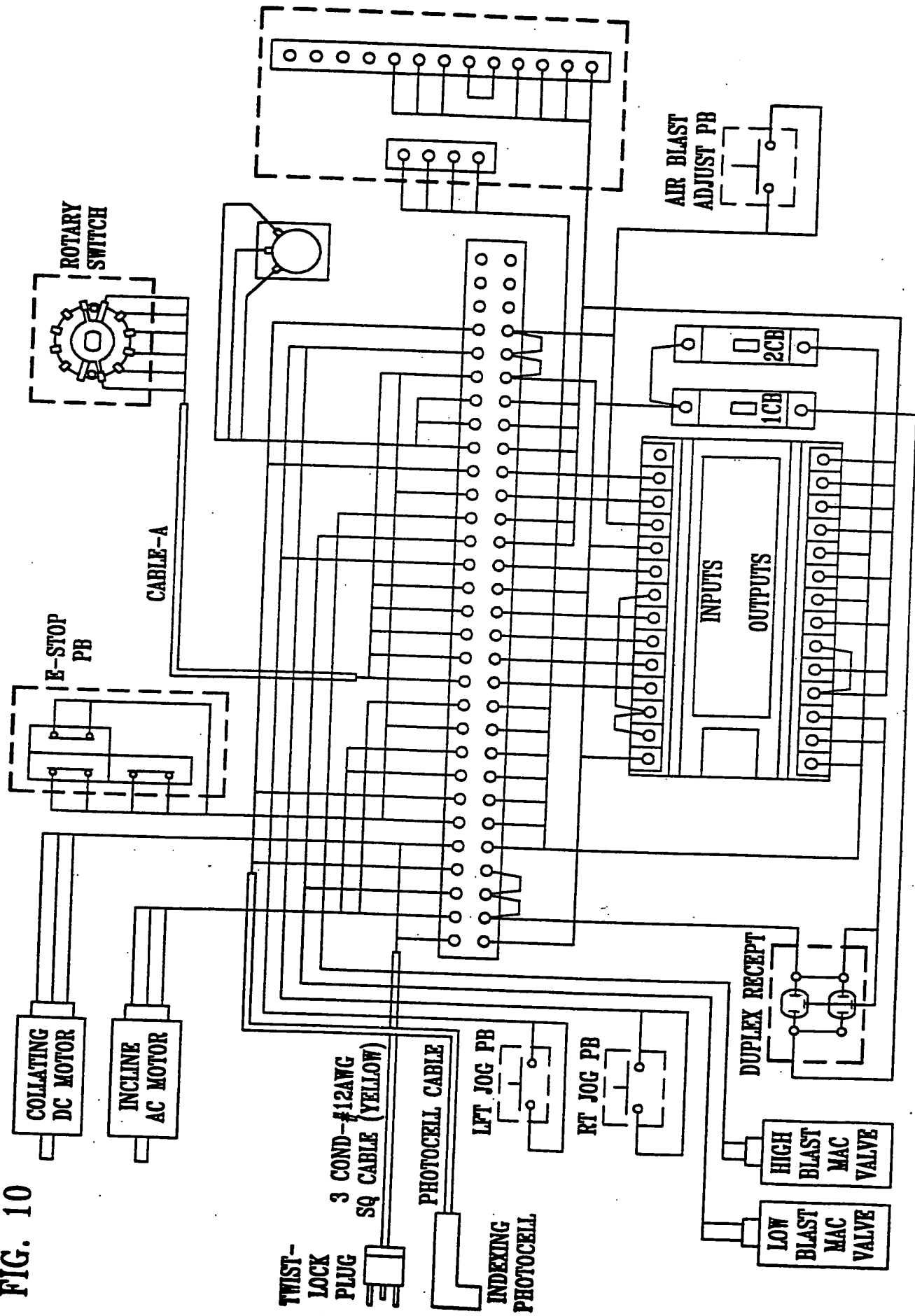


FIG. 11A

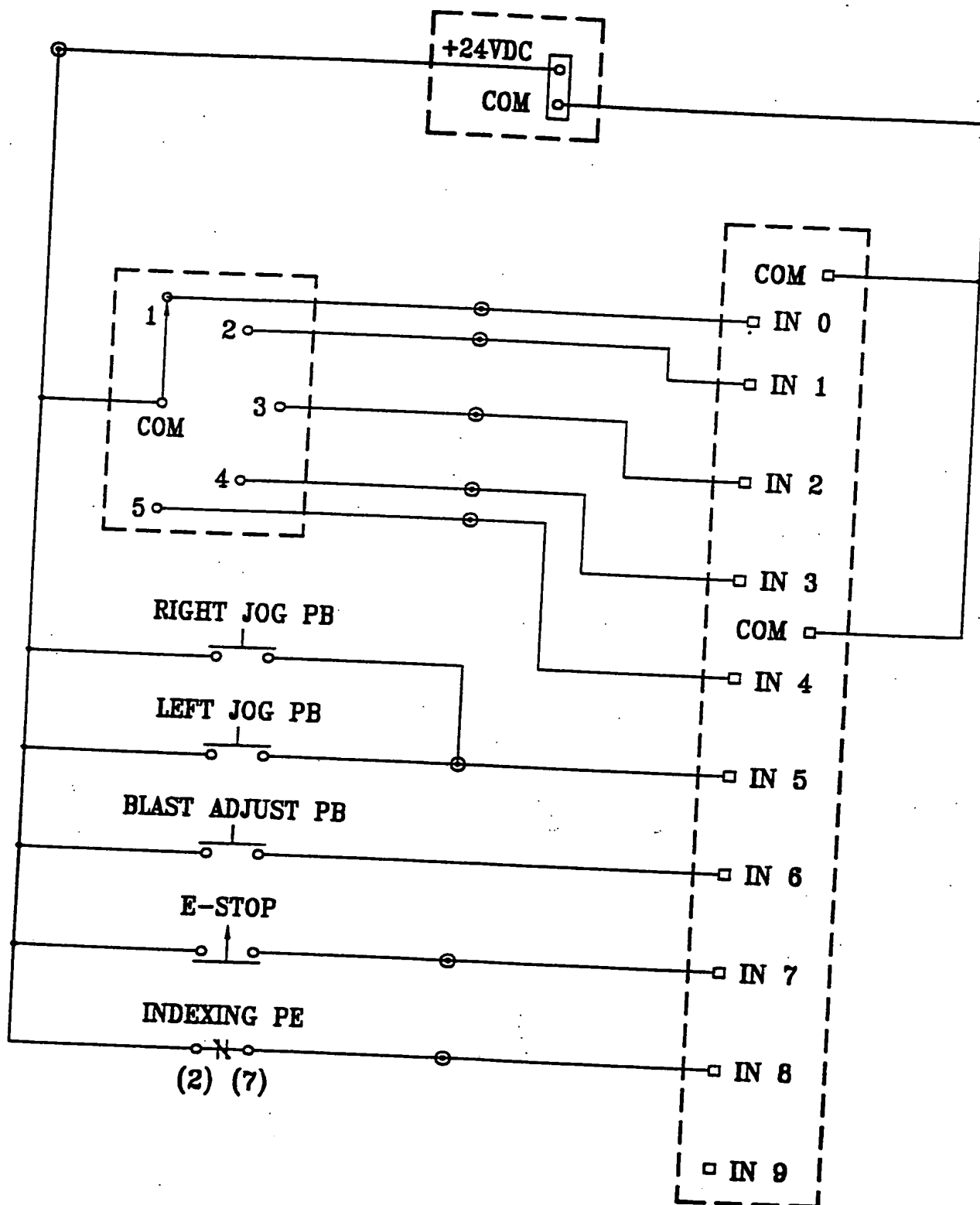
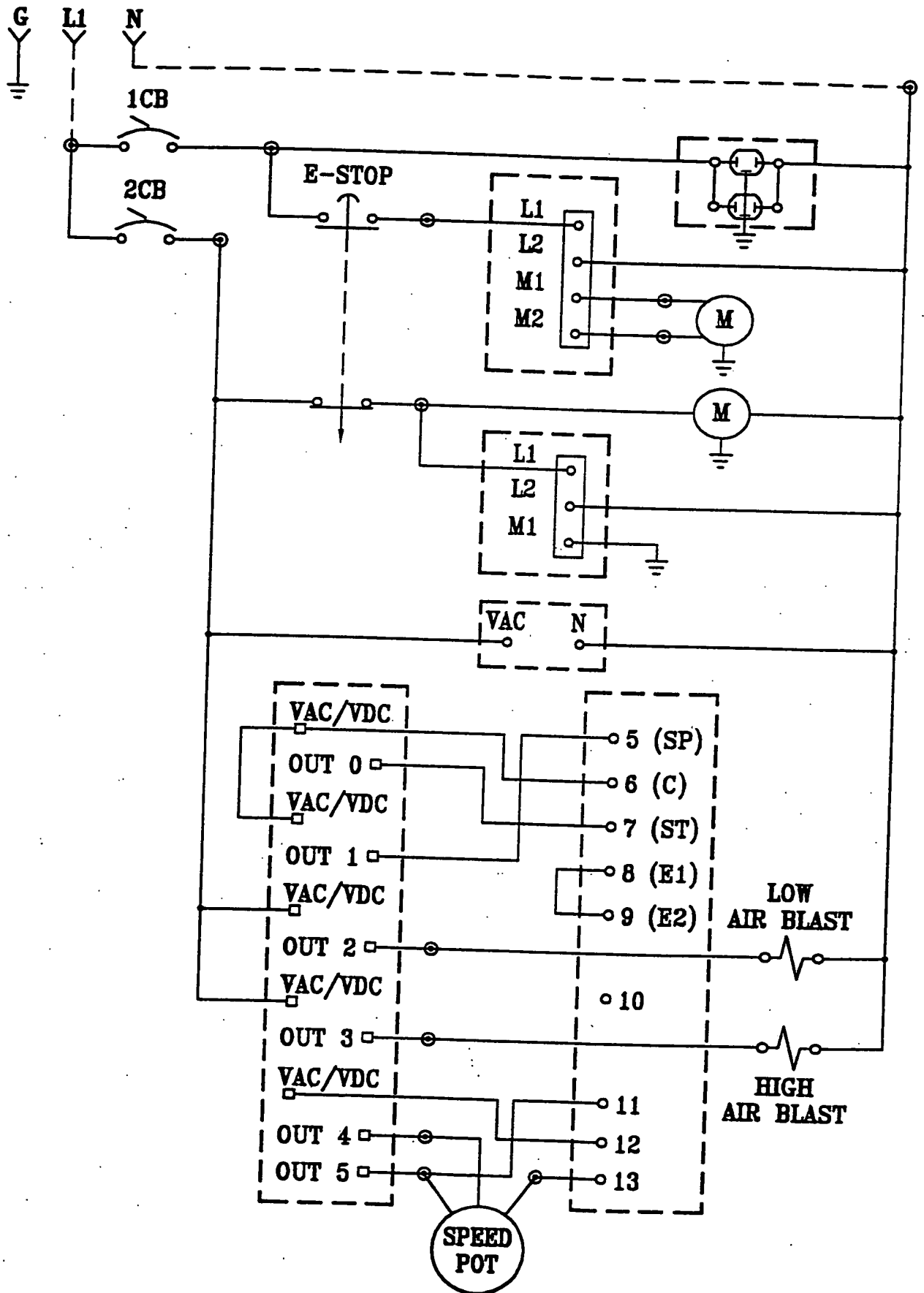


FIG. 11B

120V, 1PH, 60Hz



AIR ASSISTED COLLATOR PROGRAM LISTING

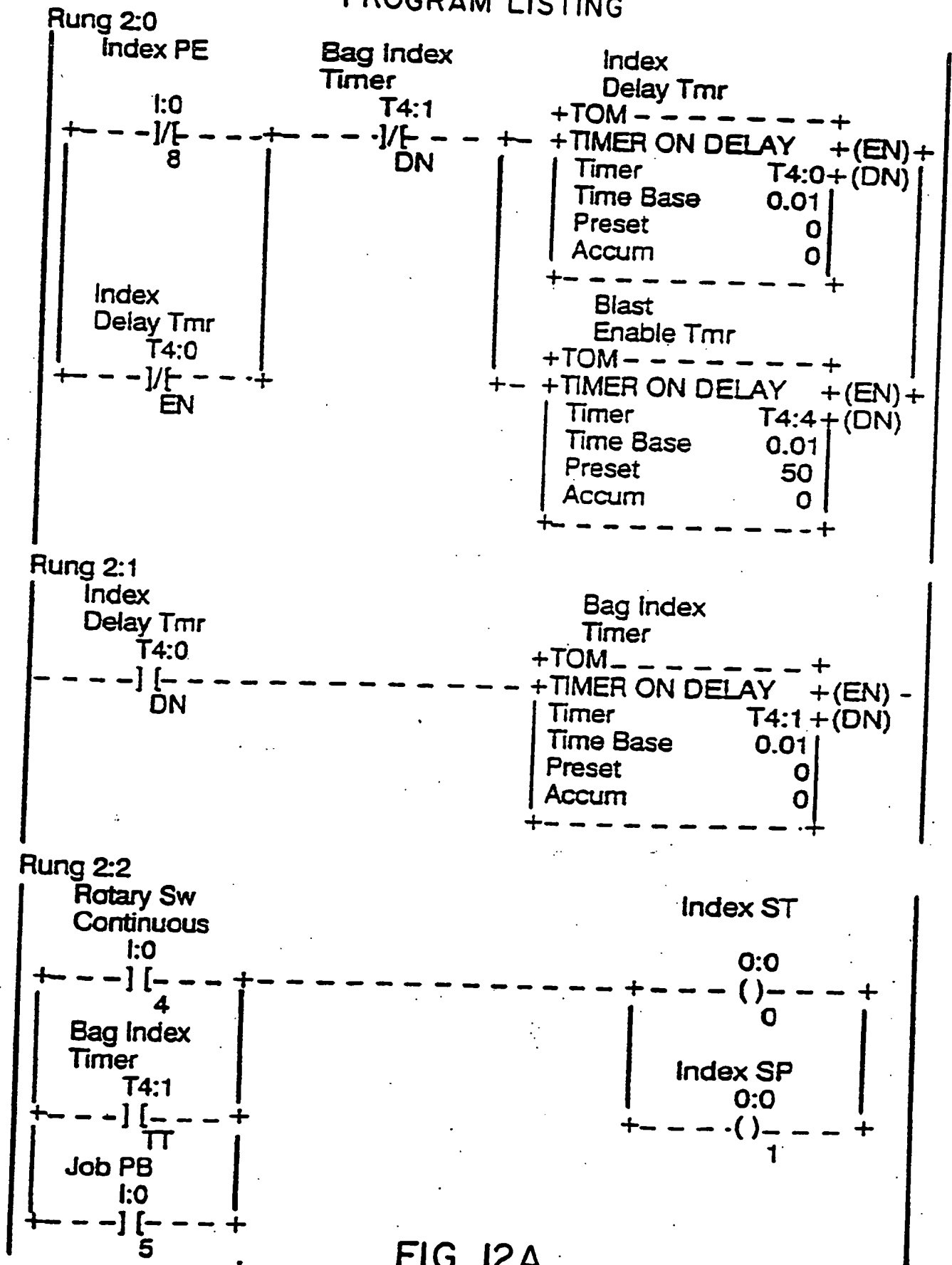
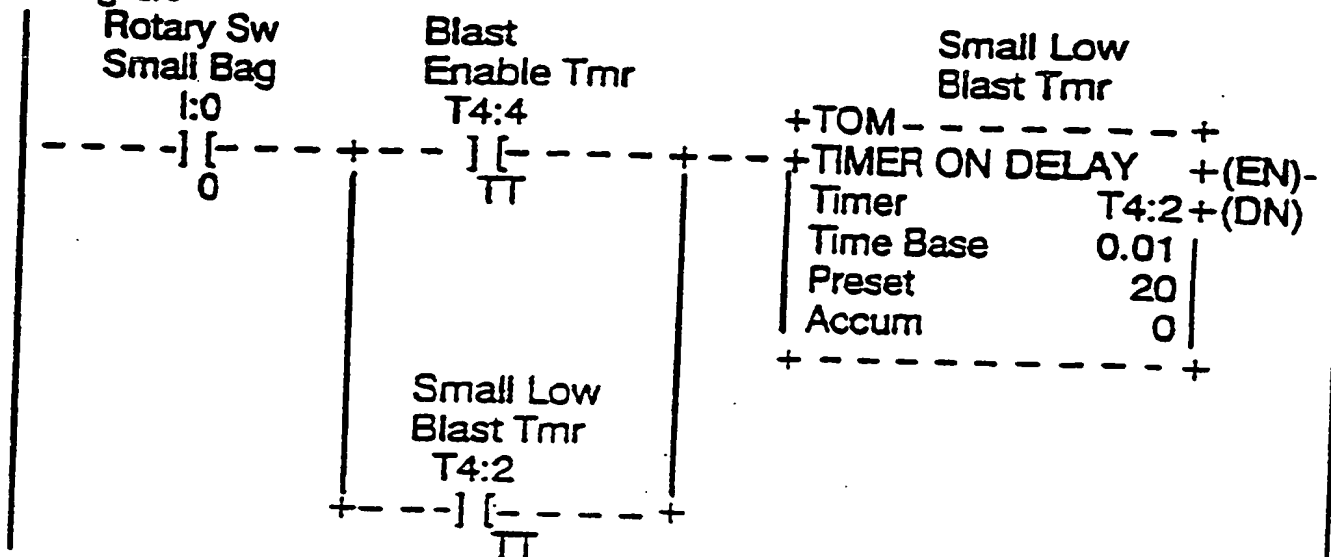


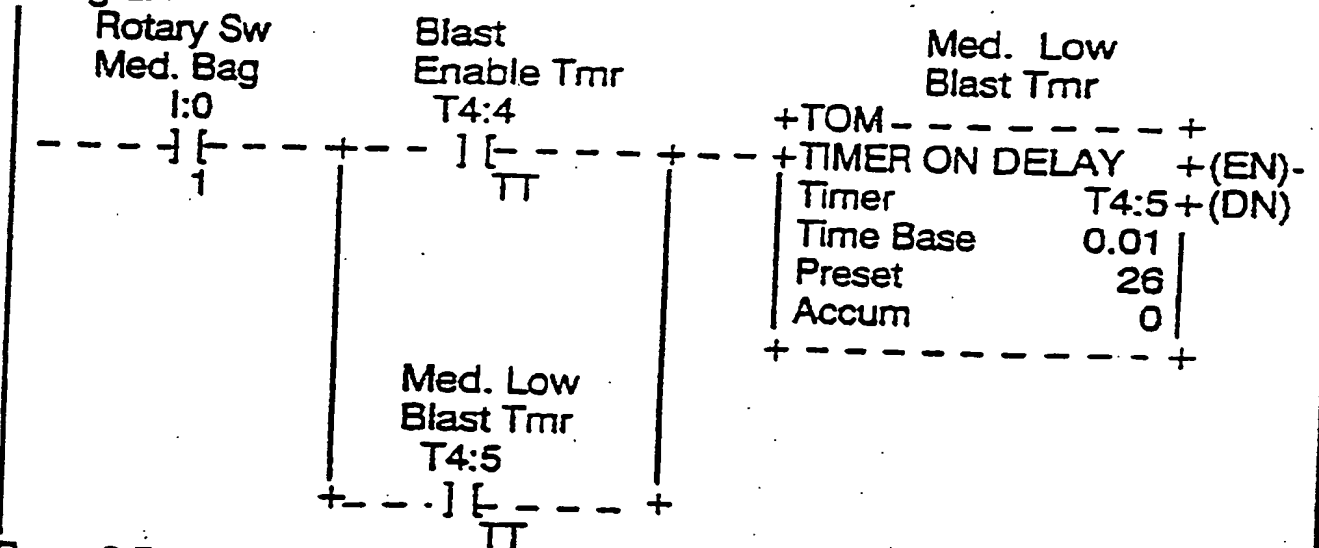
FIG. 12A

AIR ASSISTED COLLATOR PROGRAM LISTING

Rung 2:3



Rung 2:4



Rung 2:5

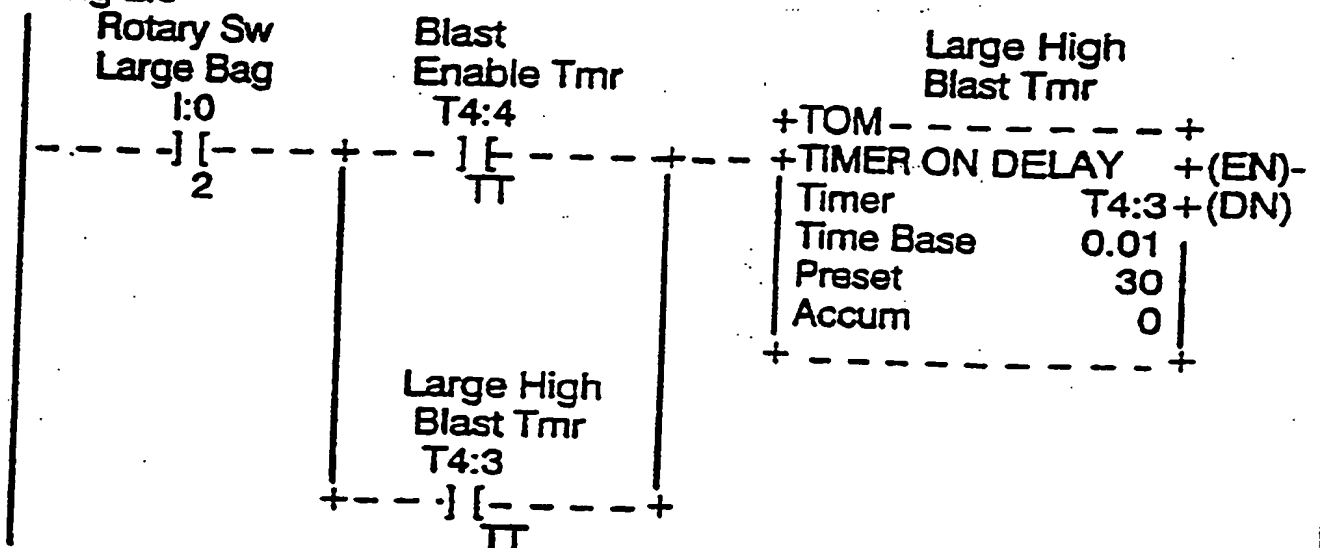


FIG. 12R

AIR ASSISTED COLLATOR PROGRAM LISTING

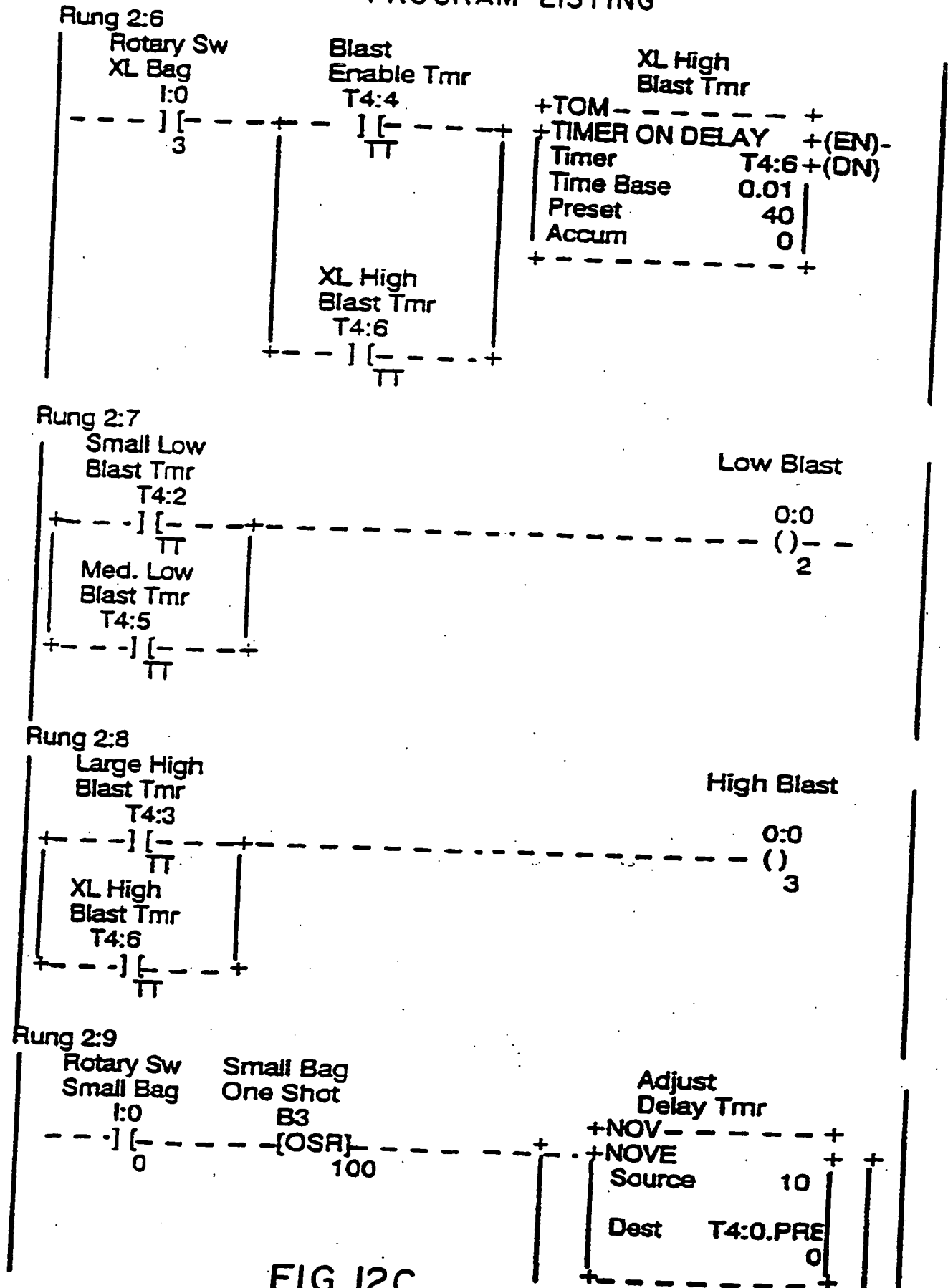


FIG. 12C

AIR ASSISTED COLLATOR PROGRAM LISTING

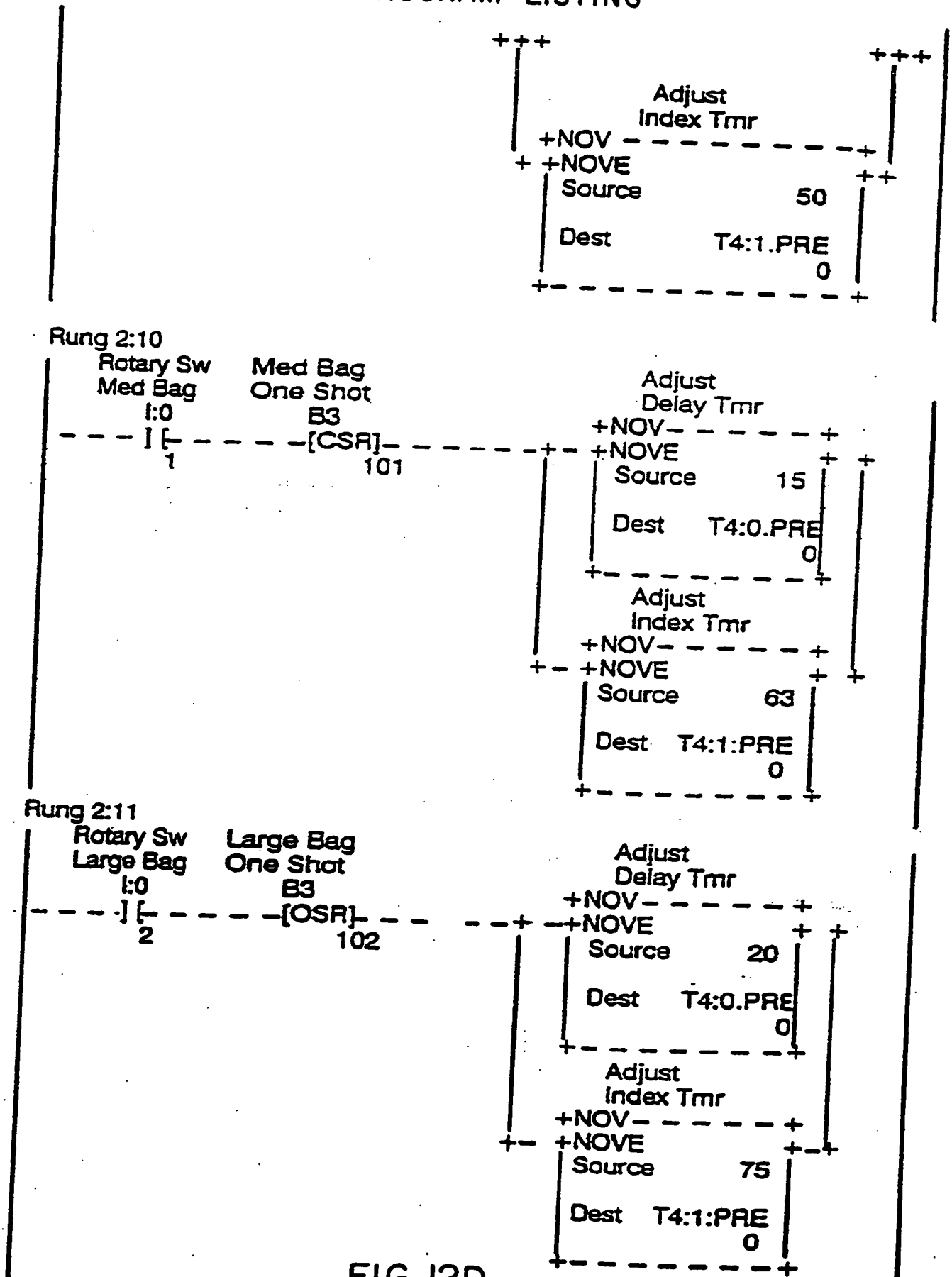
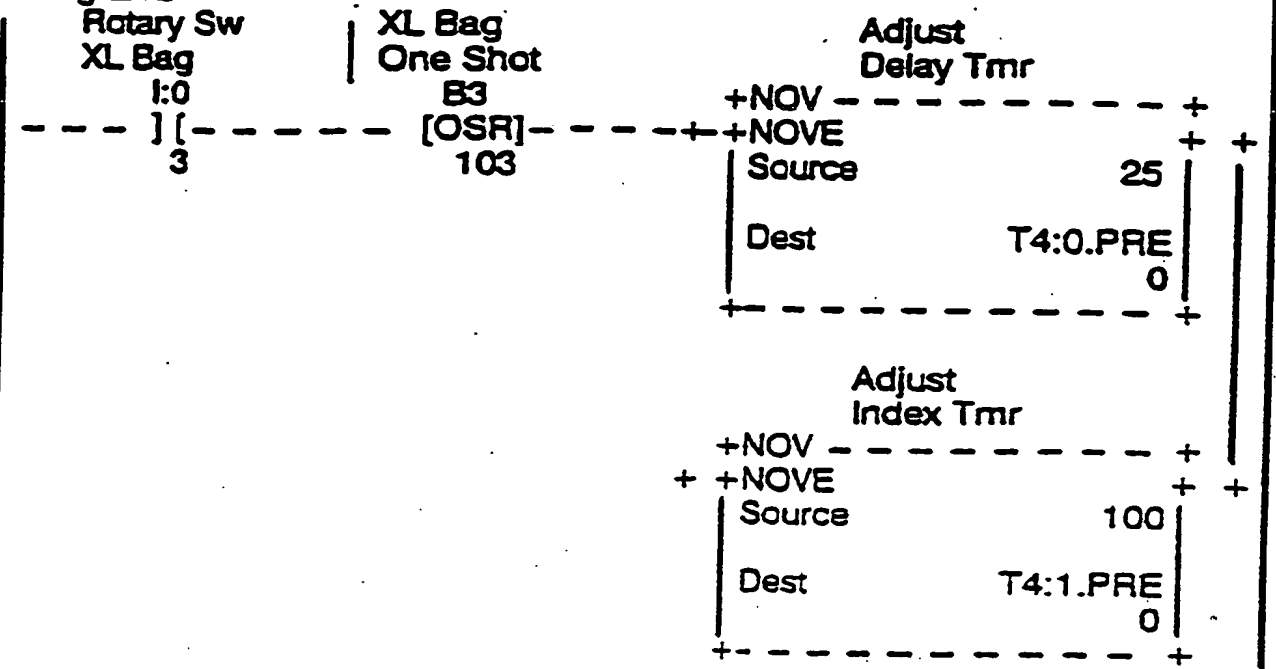


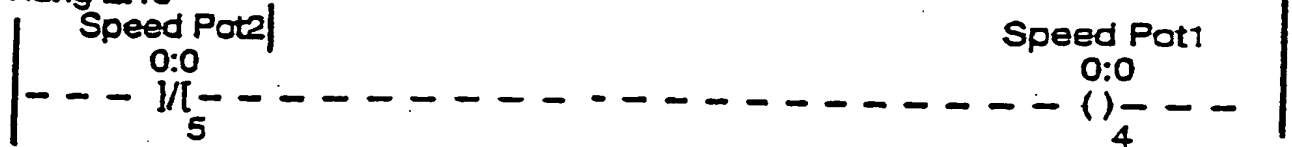
FIG 12D

AIR ASSISTED COLLATOR PROGRAM LISTING

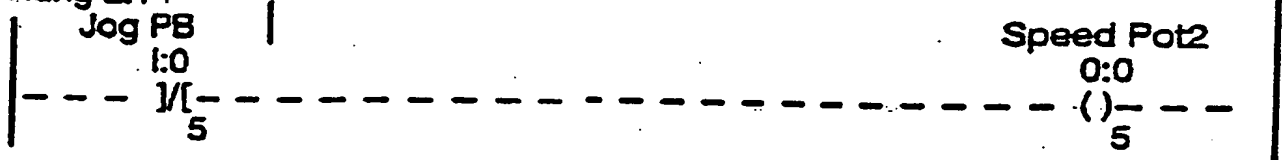
Rung 2:12



Rung 2:13



Rung 2:14



Rung 2:15

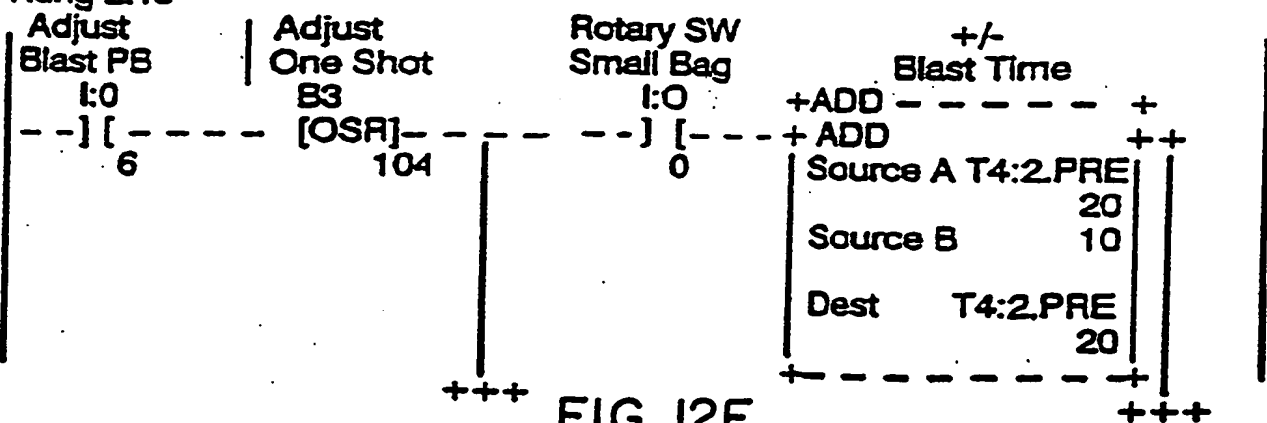
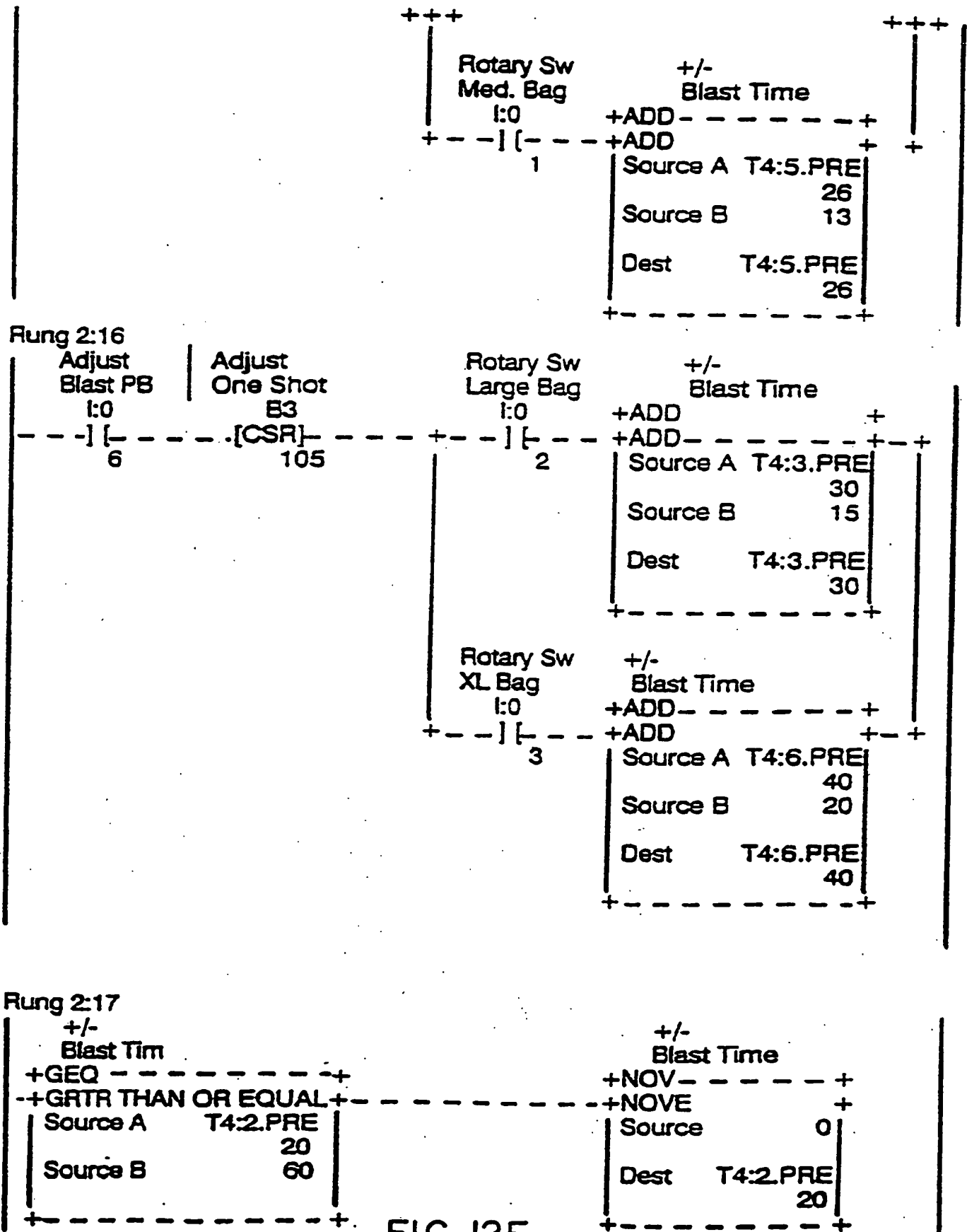


FIG. 12F

AIR ASSISTED COLLATOR PROGRAM LISTING



Rung 2:18

+/- Blast Time		+/- Blast Time	
+GEQ	-----+	+NOV	-----+
+GTR THAN OR EQUAL	+-----+	+NOVE	+-----+
Source A	T4:5.PRE	Source	0
	26		
Source B	78	Dest	T4:5.PRE
			26

• Rung 2:19

+/- Blast Time		+/- Blast Time	
+GEQ	----	+NOV	----
+GRTR THAN OR EQUAL+		+NOVE	
Source A	T4:3.PRE	Source	0
	30		
Source B	90	Dest	T4:3.PRE
			30

Rung 2:20

+/- Blast Time		+/- Blast Time	
+GEQ	+	+NOV	+
+GRTR THAN OR EQUAL+-		+NOVE+-	
Source A	T4:6.PRE	Source	0
	40		
Source B	120	Dest	T4:6.PRE
			40

Rung 2:21

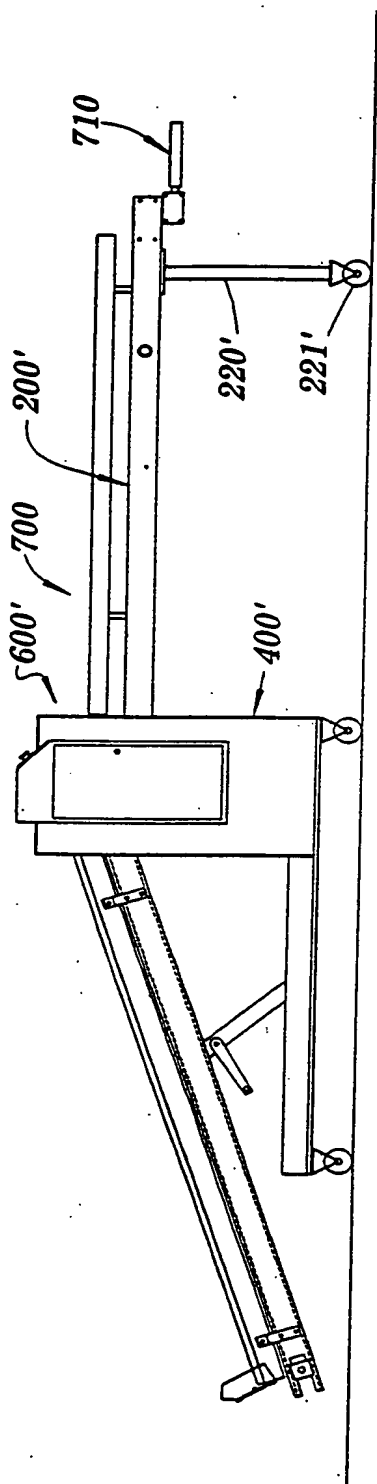


Fig. 13

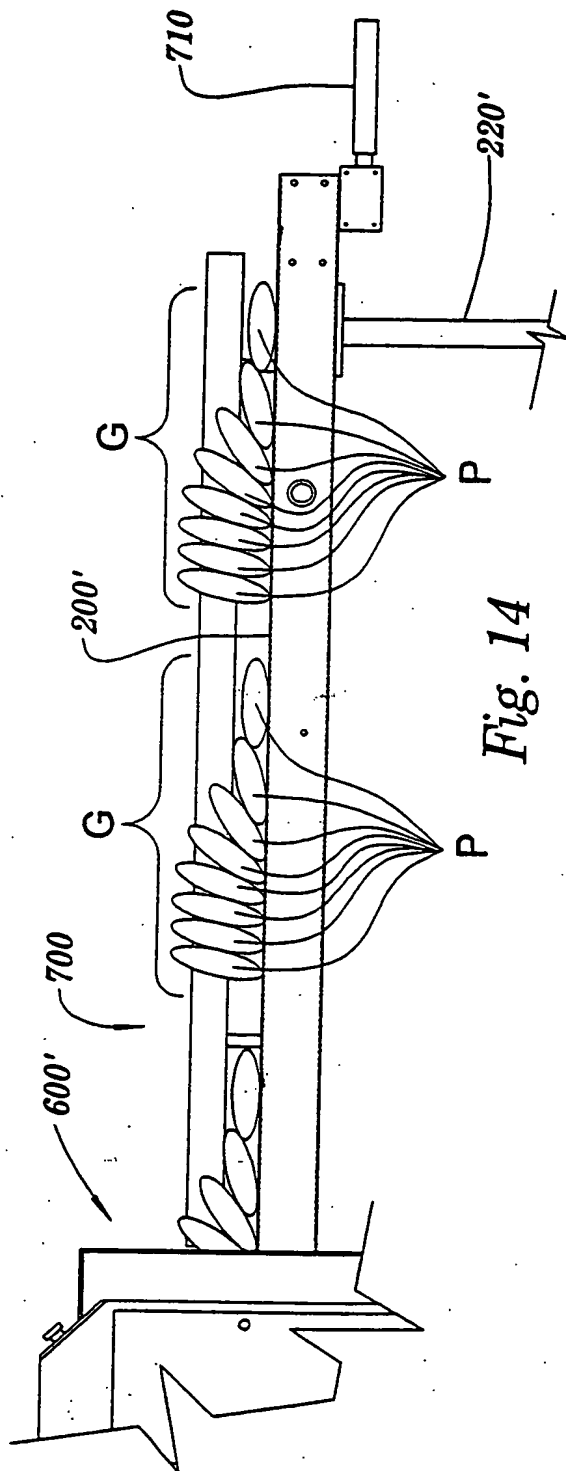


Fig. 14

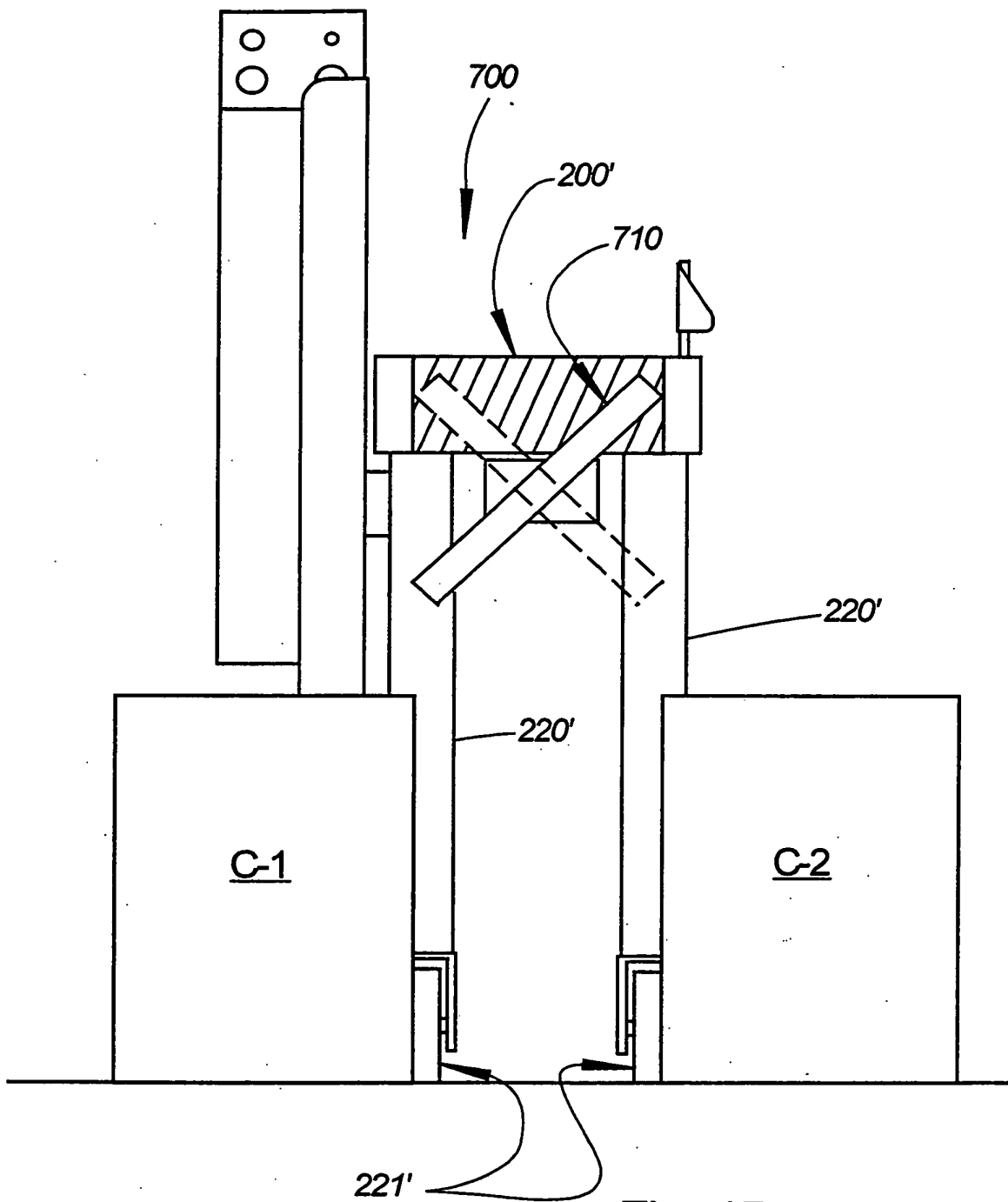


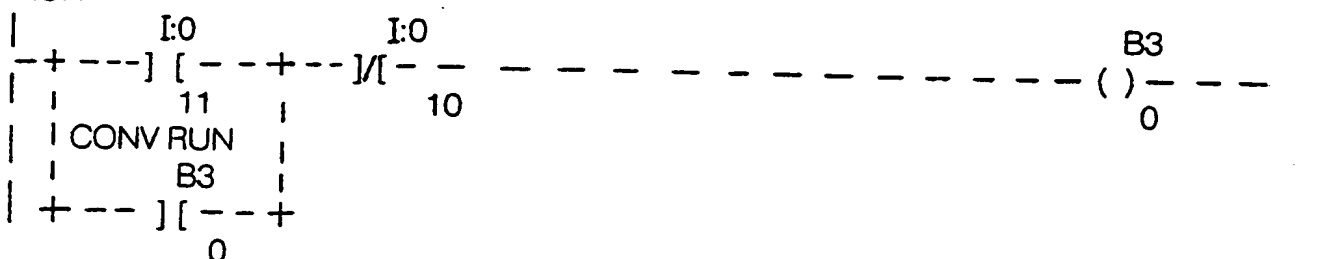
Fig. 15

RUNG 2:0 - START/STOP CONTROL.

RUNG 2:0 START PB E-STOP

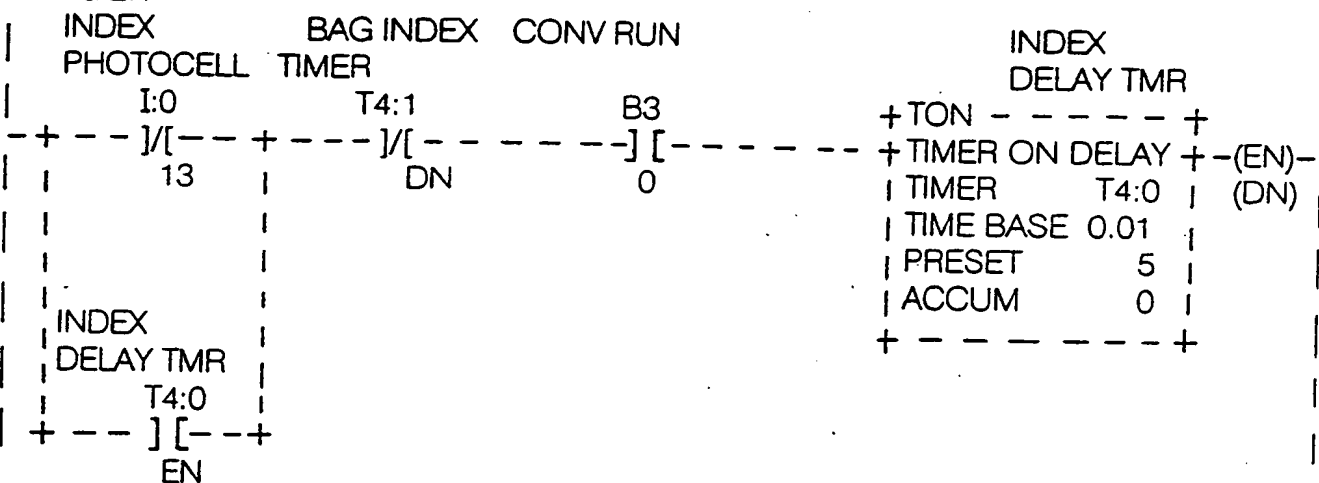
CONV

RUN

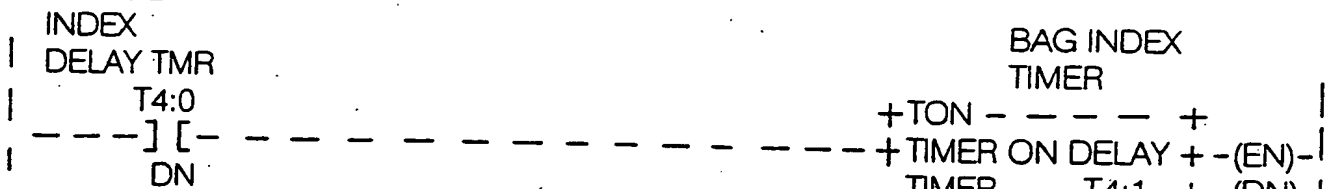


RUNG 2:1 AND 2:2 - INDEXING CONTROLS.

RUNG 2:1



RUNG 2:2



RUNGS 2:3 THRU 2:5-AIR BLAST TIMER CONTROLS.

RUNG 2:3

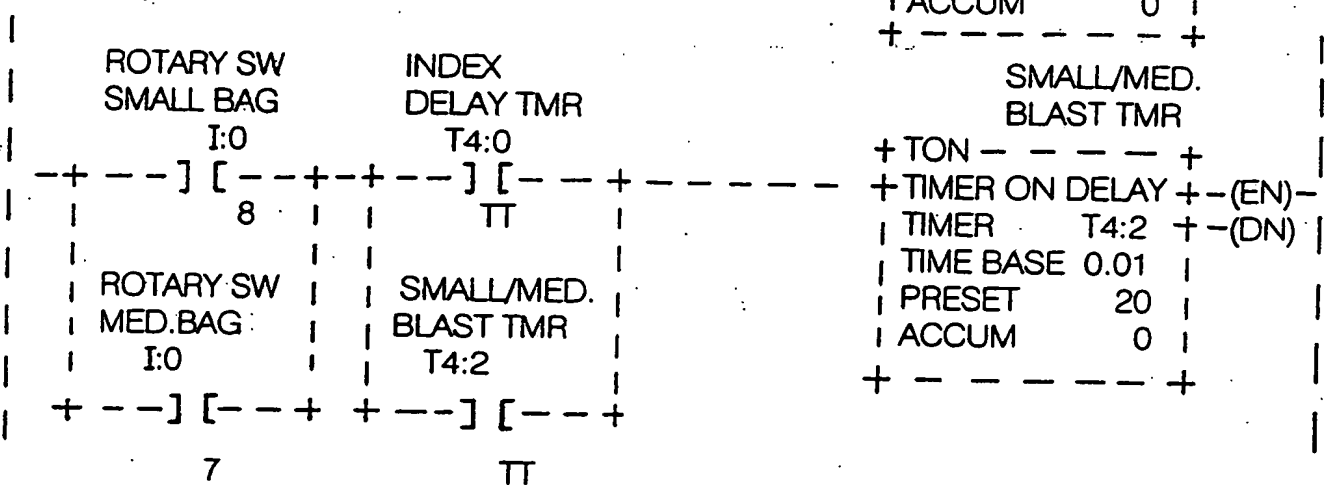


FIG.16A

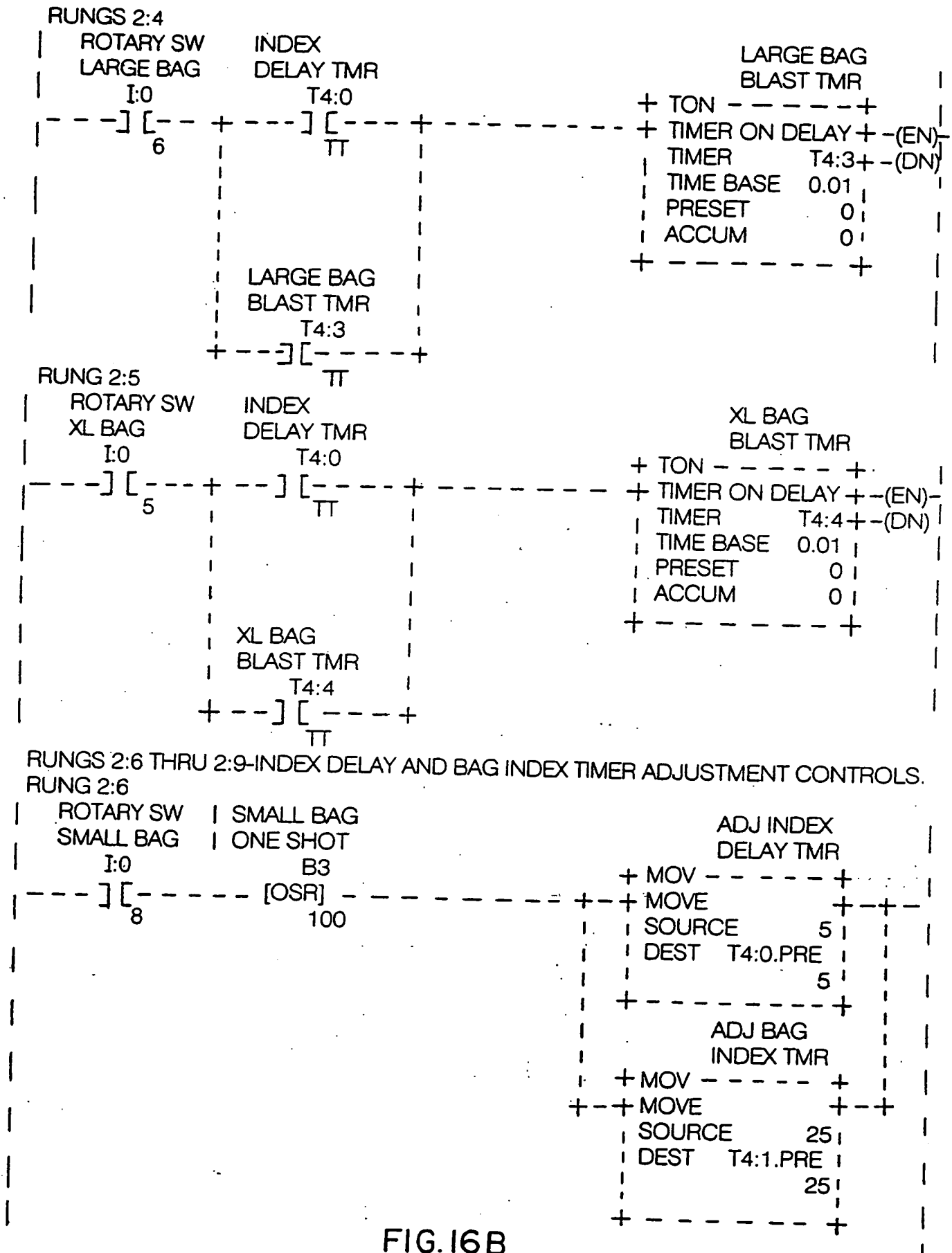
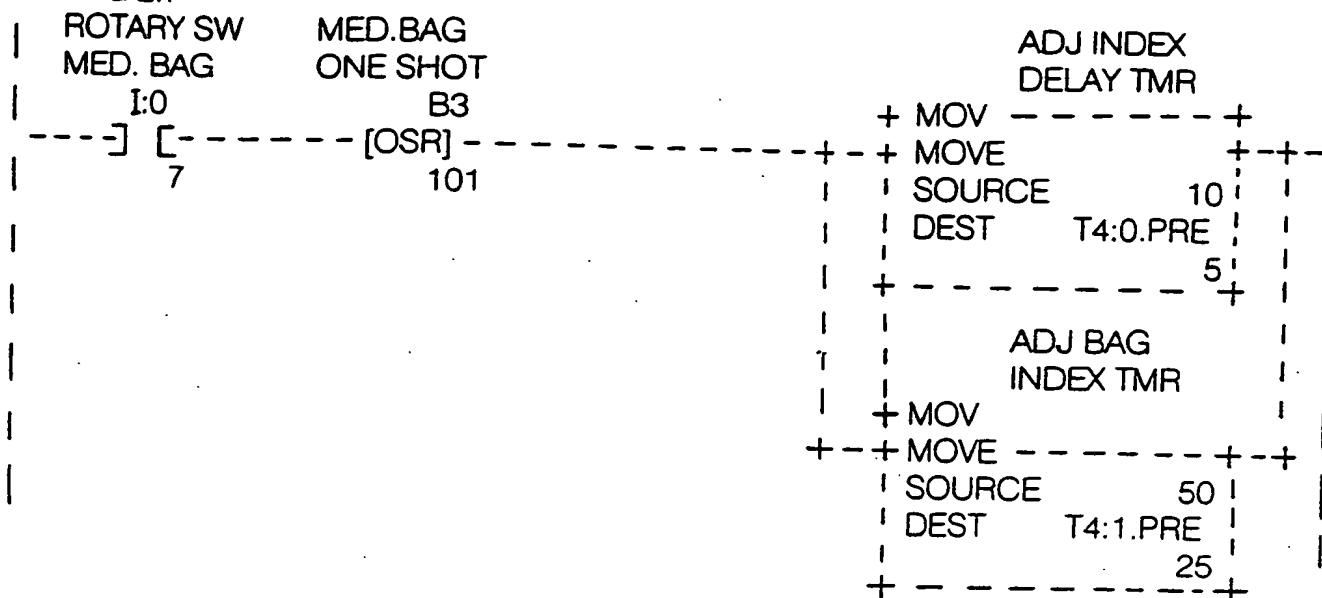


FIG.16B

RUNGS 2:6 THRU 2:9-INDEX DELAY AND BAG INDEX TIMER ADJUSTMENT CONTROLS.

RUNG 2:7



RUNGS 2:6 THRU 2:9-INDEX DELAY AND BAG INDEX TIMER ADJUSTMENT CONTROLS.

RUNG 2:8

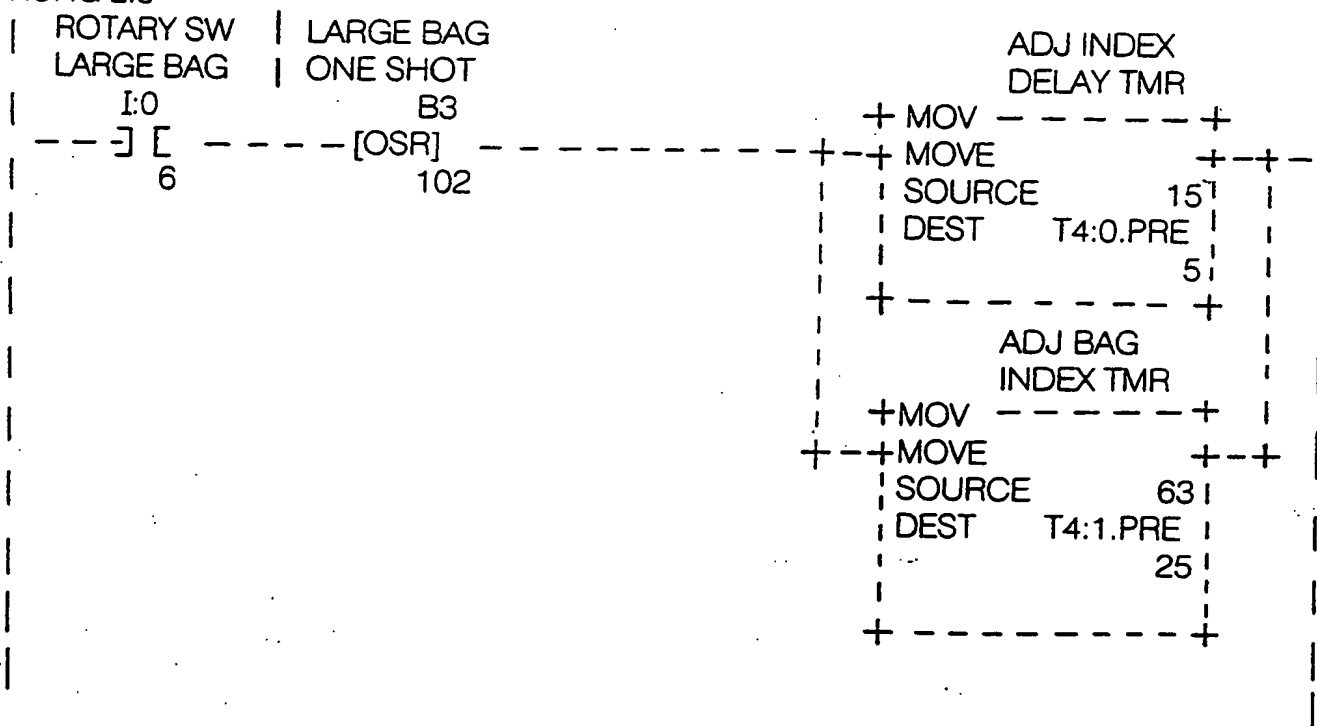
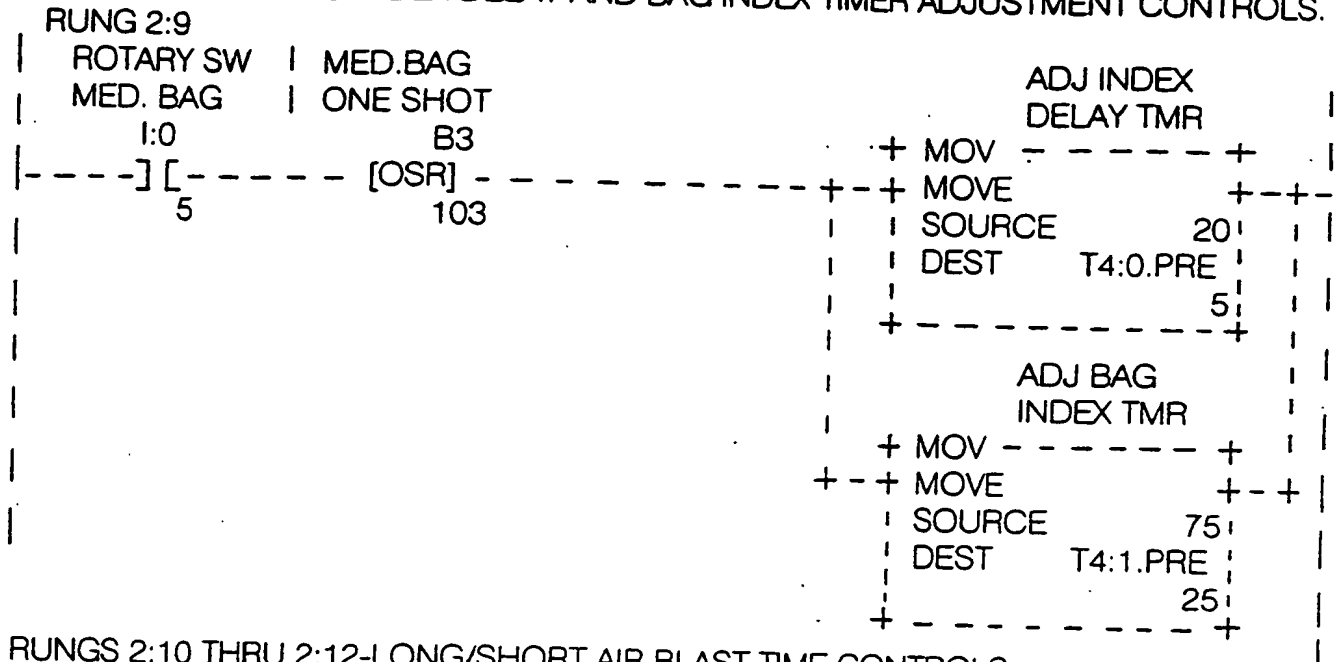


FIG. 16C

RUNGS 2:6 THRU 2:9-INDEX DELAY AND BAG INDEX TIMER ADJUSTMENT CONTROLS.



RUNGS 2:10 THRU 2:12-LONG/SHORT AIR BLAST TIME CONTROLS.

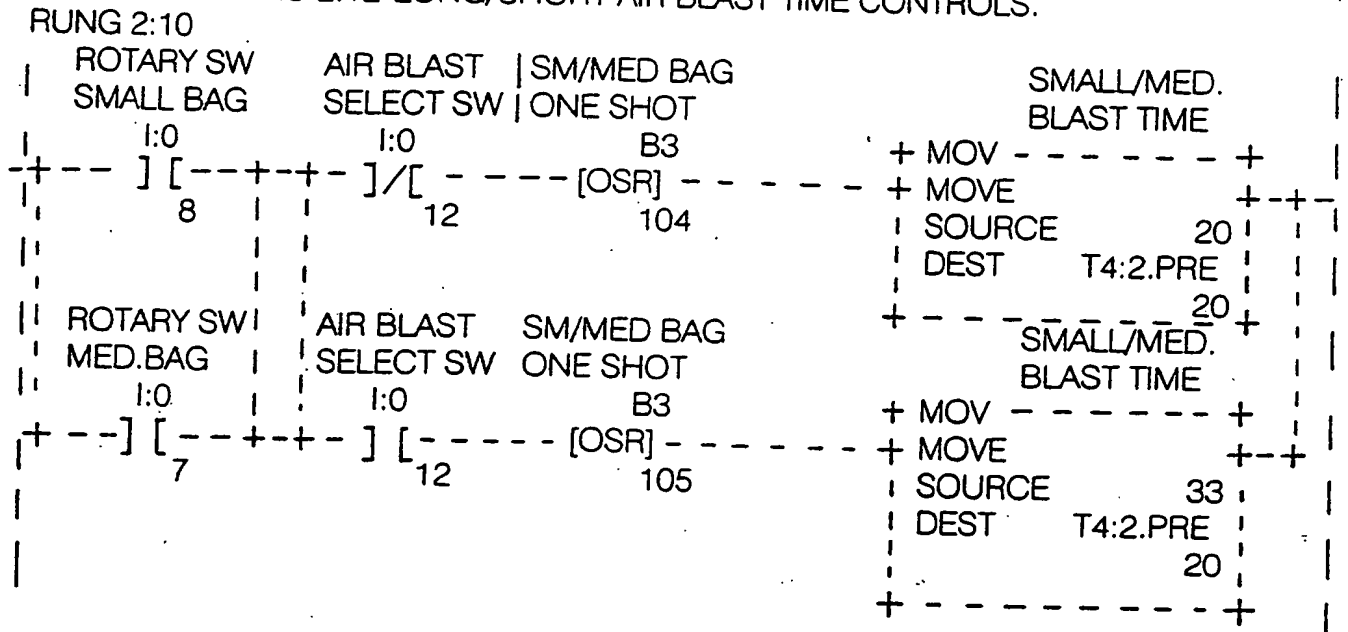


FIG. 16D

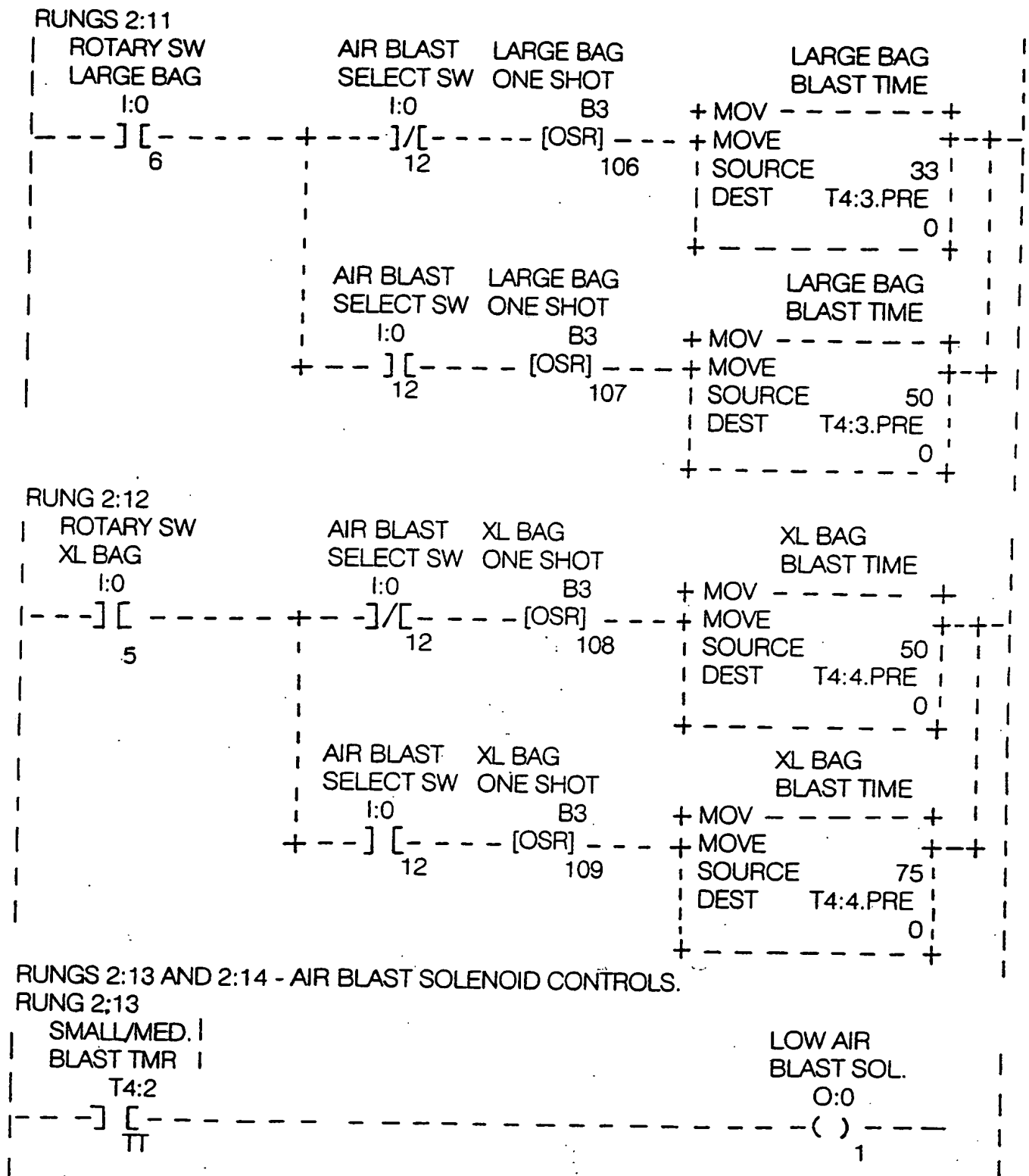
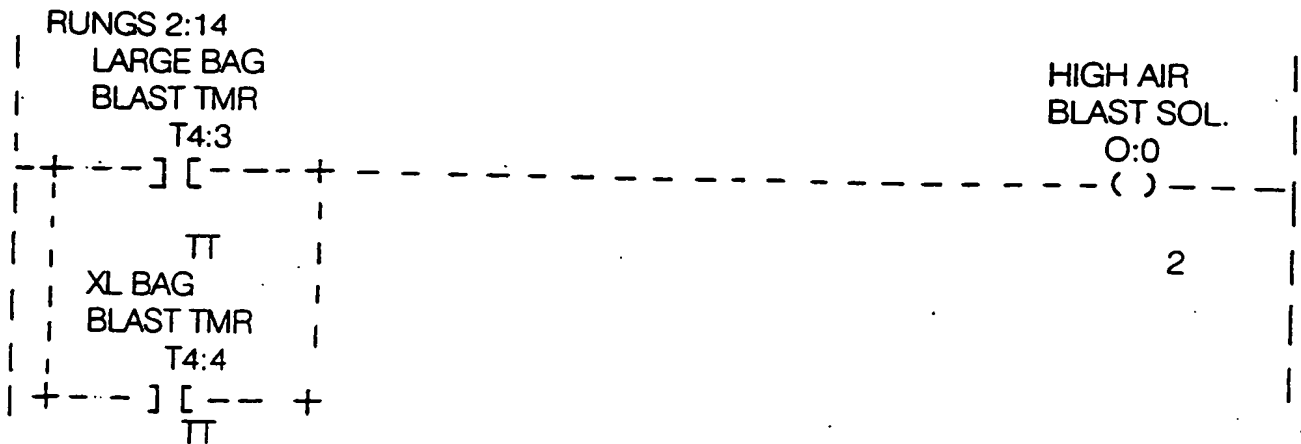


FIG. 16E



RUNGS 2:15 THRU 2:22 - DC MOTOR SPEED CONTROLS.

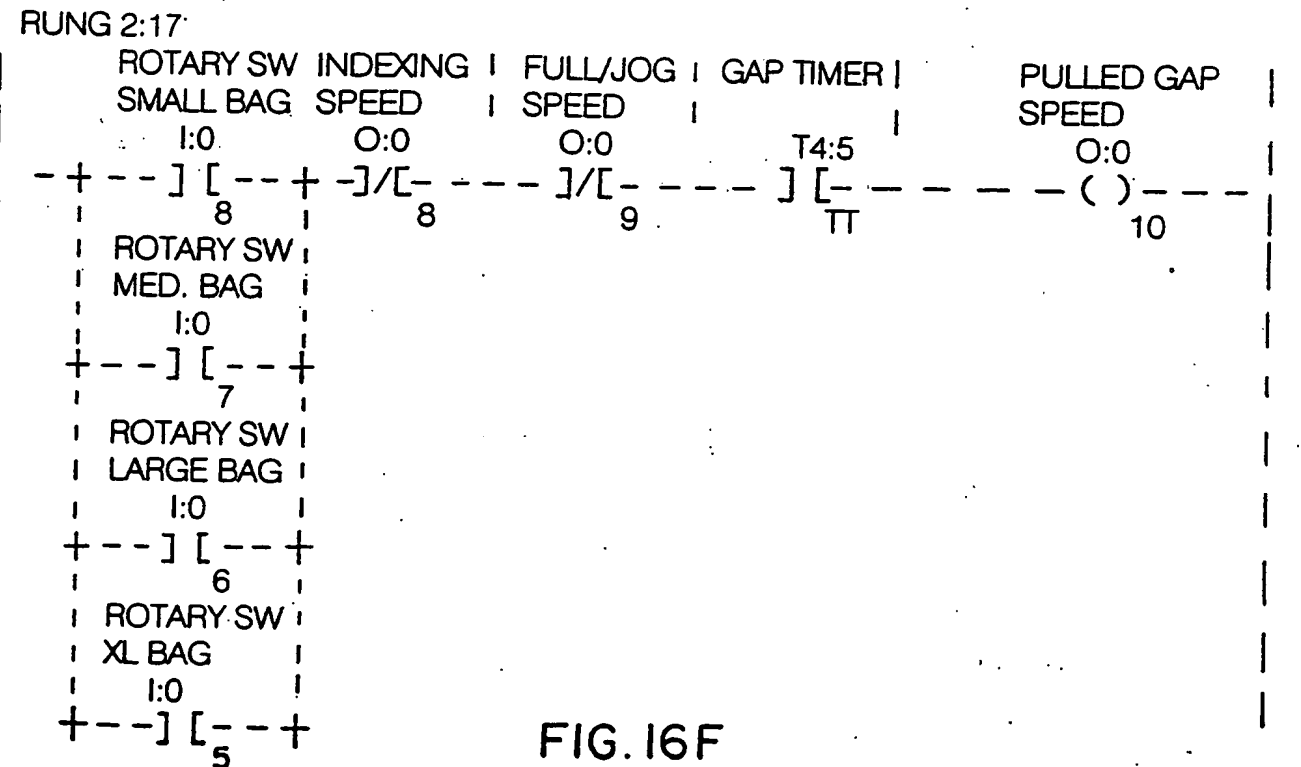
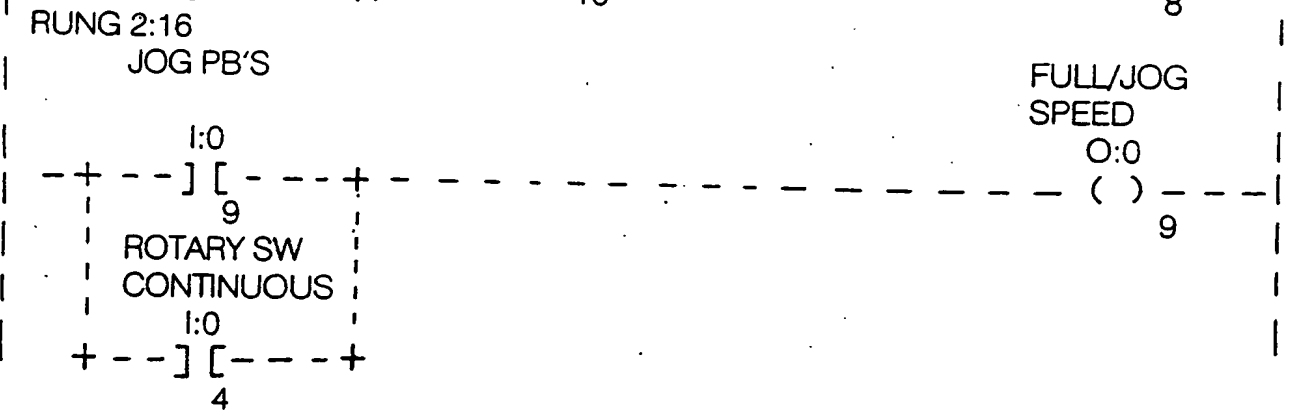
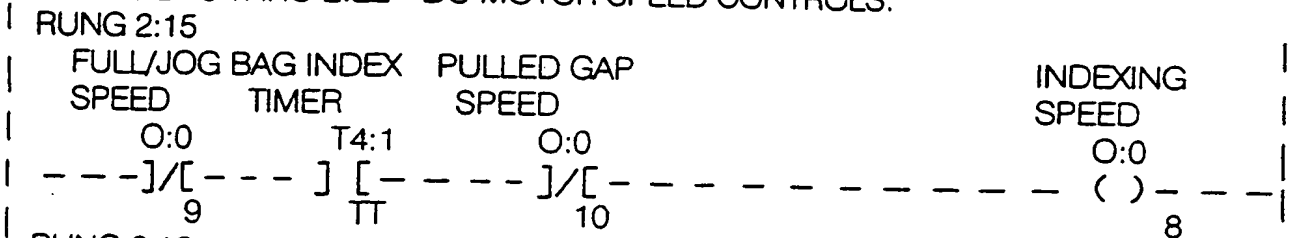


FIG. 16F

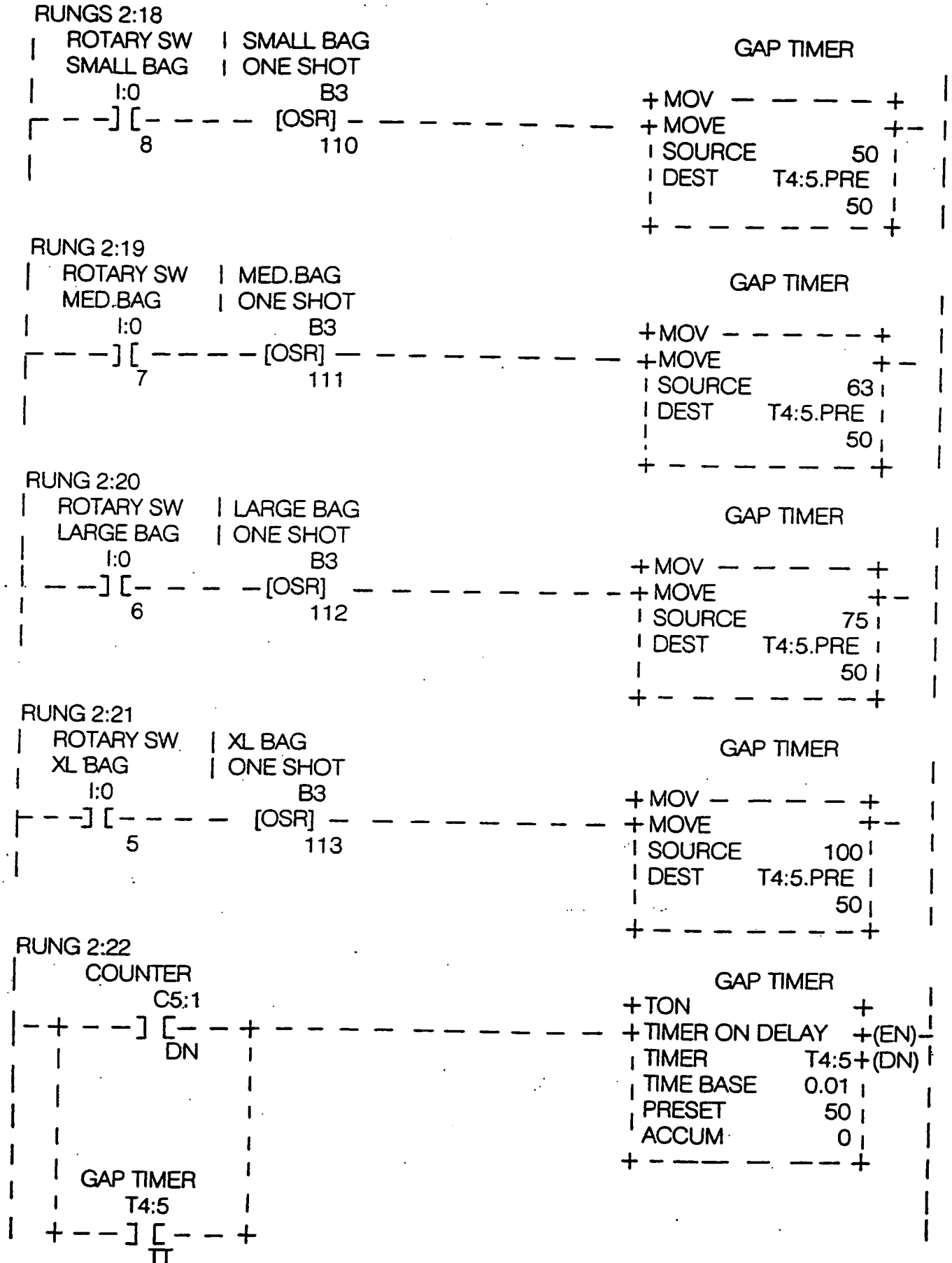
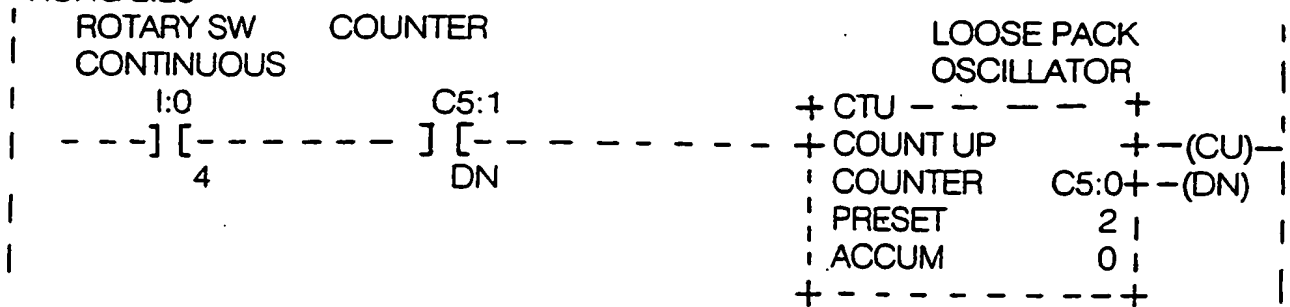


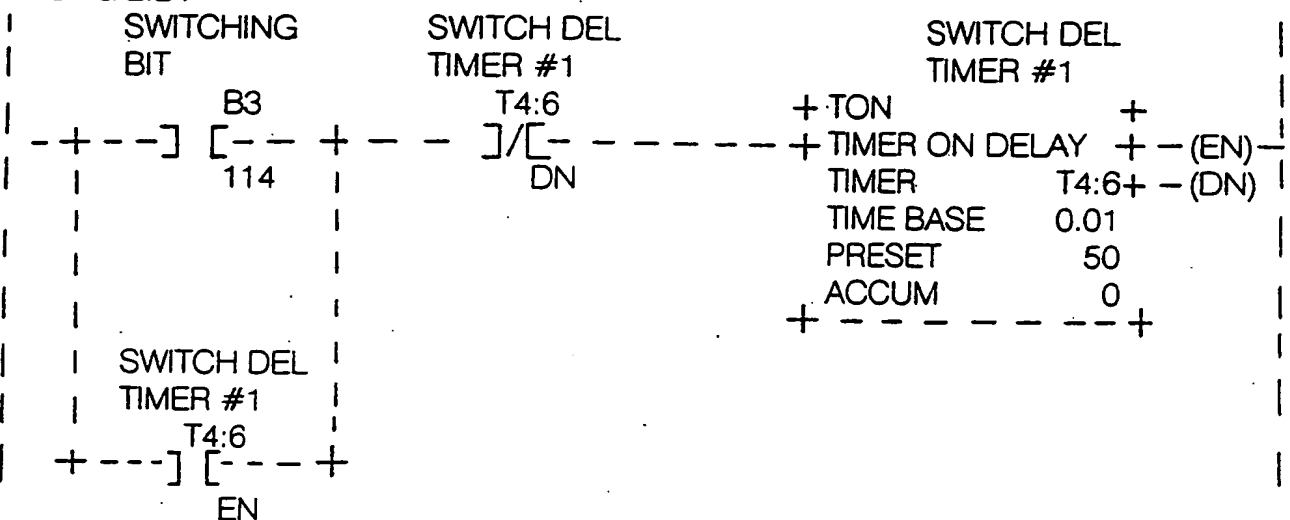
FIG. 16G

RUNGS 2:23 THRU 2:28 - OPTIONAL LOOSE PACK CONTROLS.

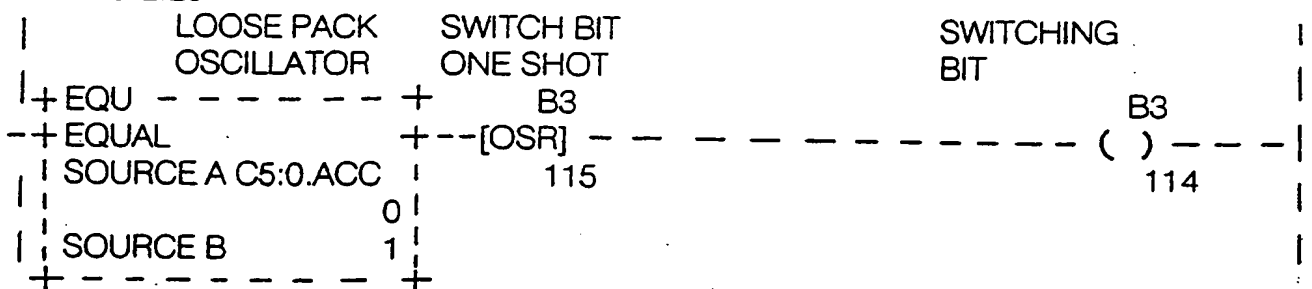
RUNG 2:23



RUNG 2:24



RUNG 2:25



RUNG 2:26

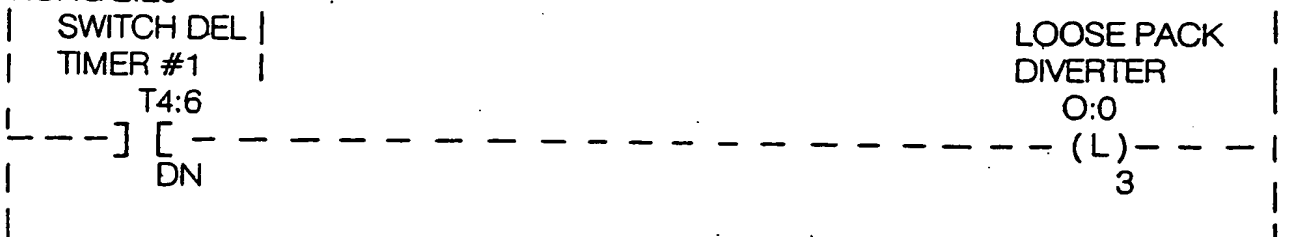
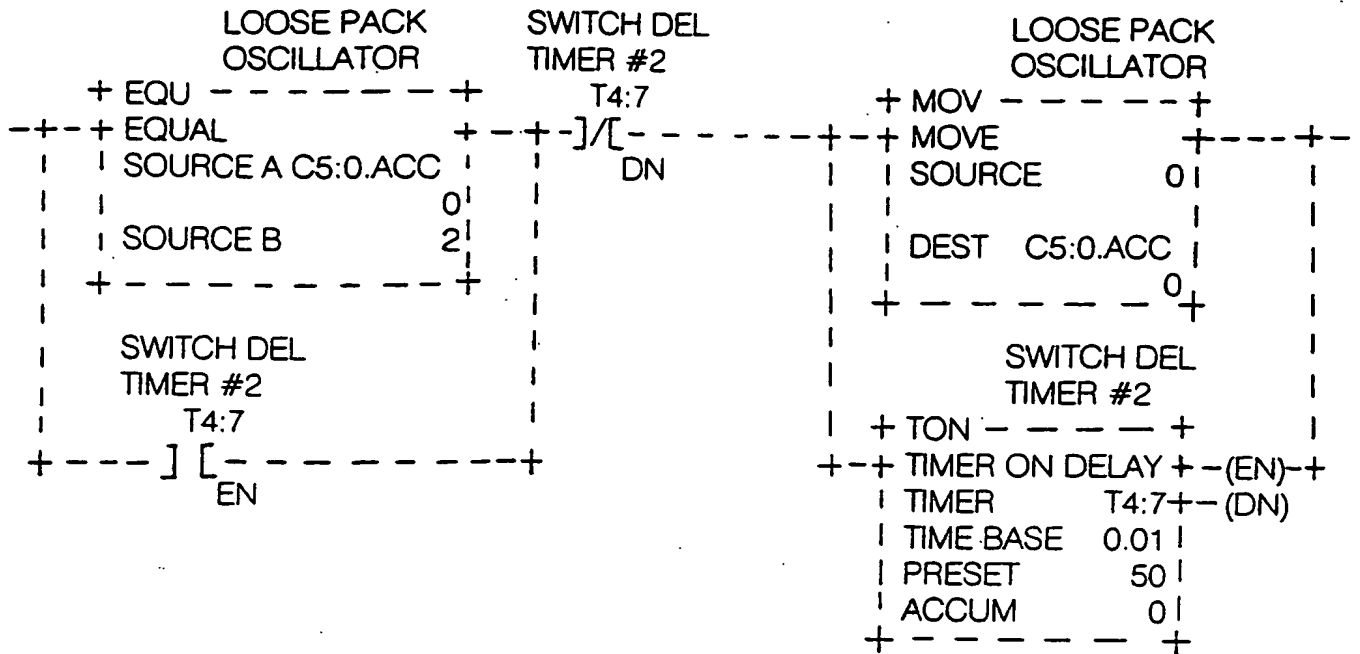


FIG. 16H

RUNGS 2:27



RUNG 2:28



RUNGS 2:29 THRU 2:32-STROBE CONTROLS. THE OUTPUTS WILL STROBE ONCE WHENEVER THE START BUTTON IS PRESSED, OR WHEN THE COUNTER REACHES IT'S COUNT. THIS WILL LOAD THE VALUE ON THE THUMBWHEEL SWITCHES INTO MEMORY.

RUNG 2:29

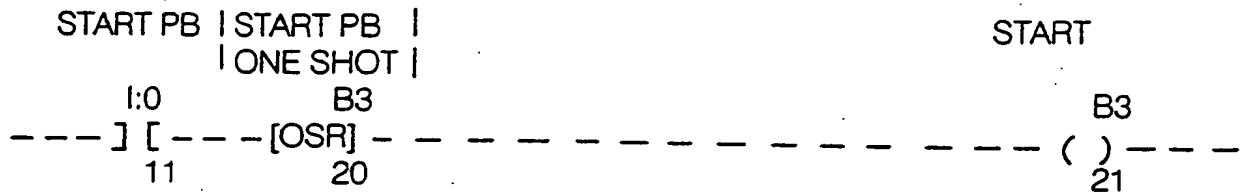


FIG.16I

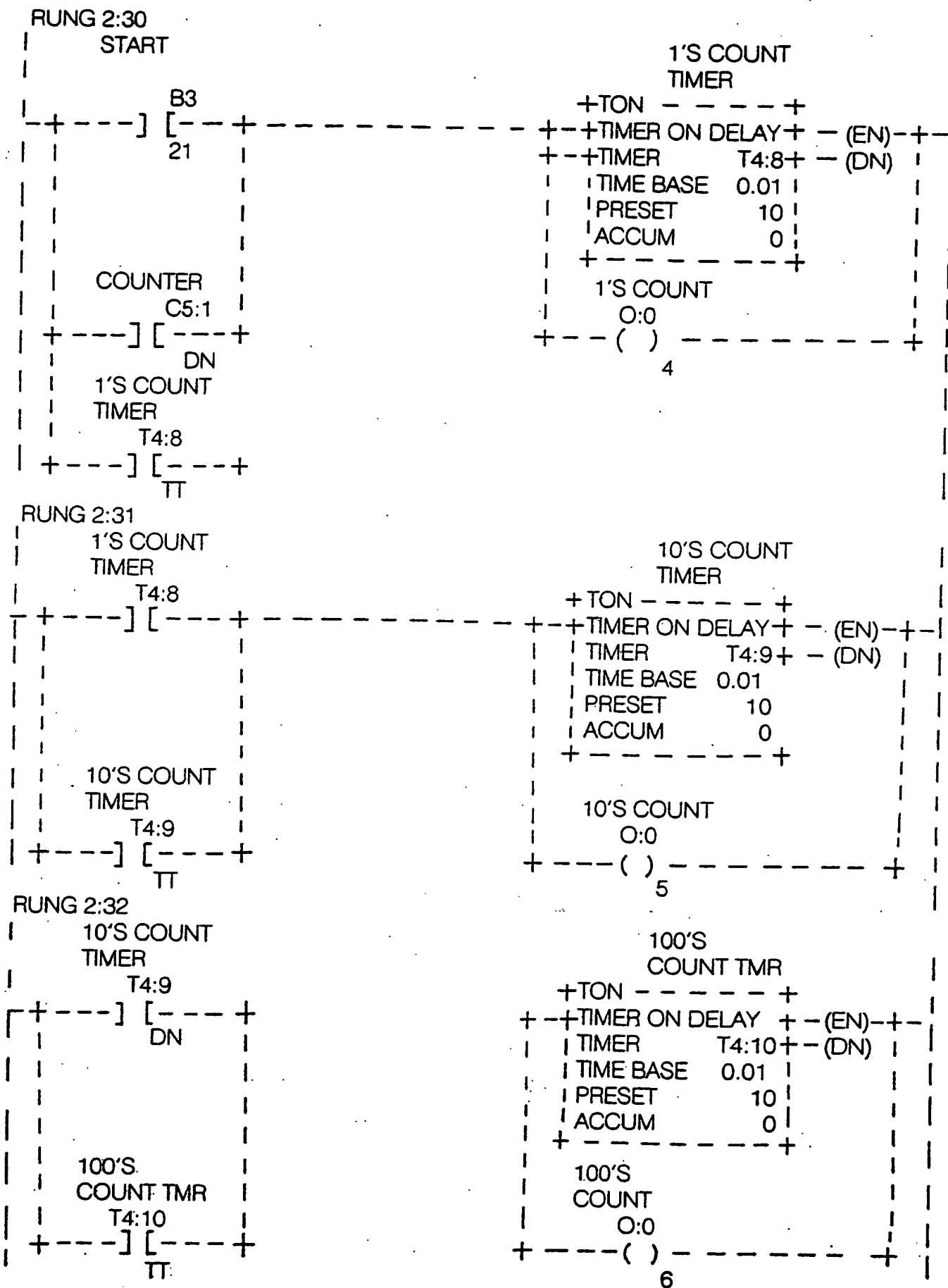
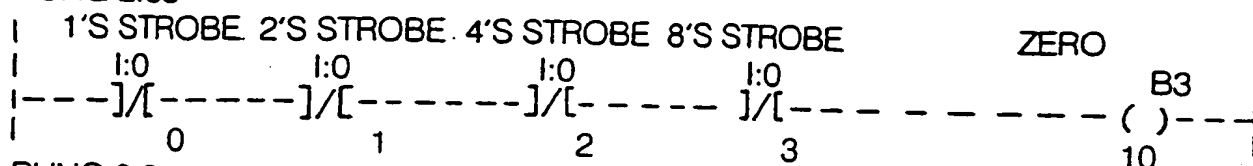


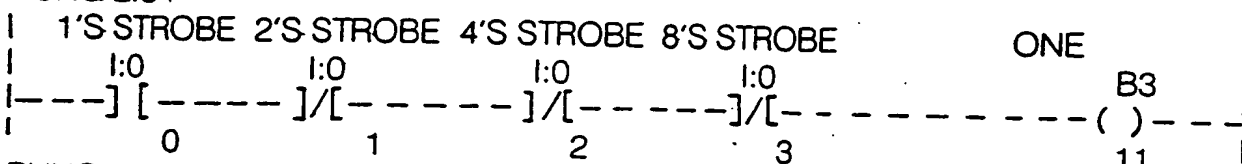
FIG. 16J

RUNGS 2:33 THRU 2:42-NUMBER CONTROL FOR ALL THUMBWHEEL SWITCHES.

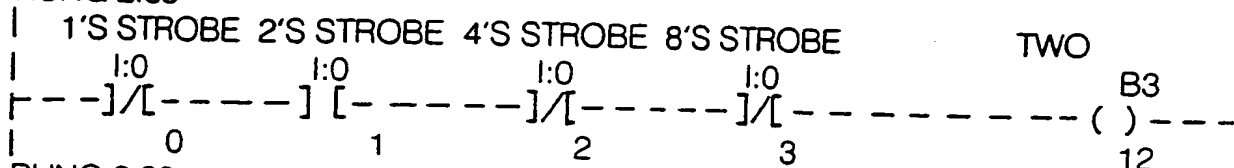
RUNG 2:33



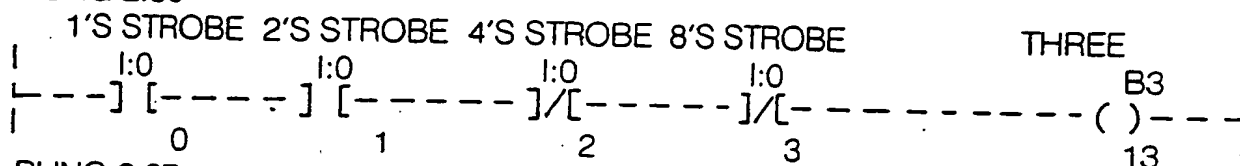
RUNG 2:34



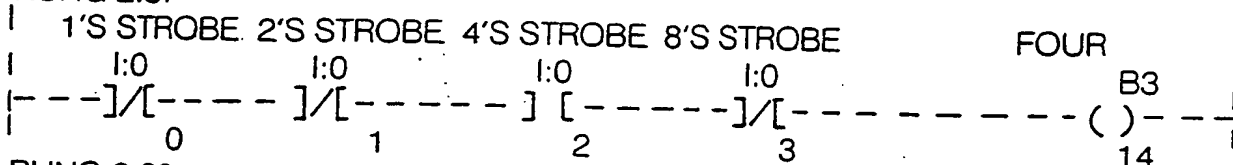
RUNG 2:35



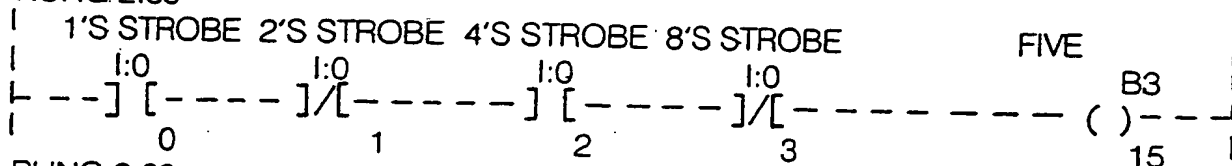
RUNG 2:36



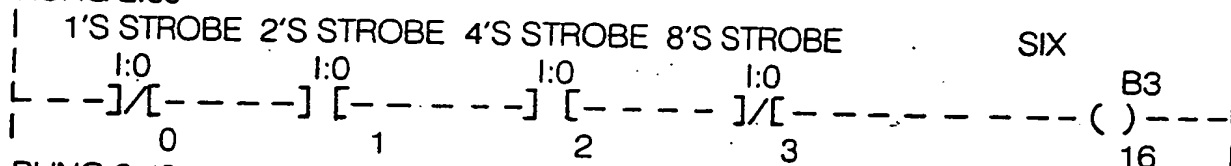
RUNG 2:37



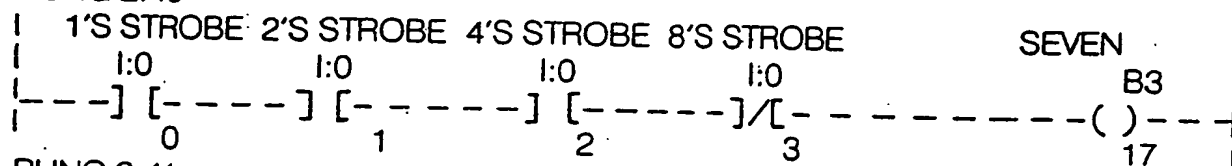
RUNG 2:38



RUNG 2:39



RUNG 2:40



RUNG 2:41

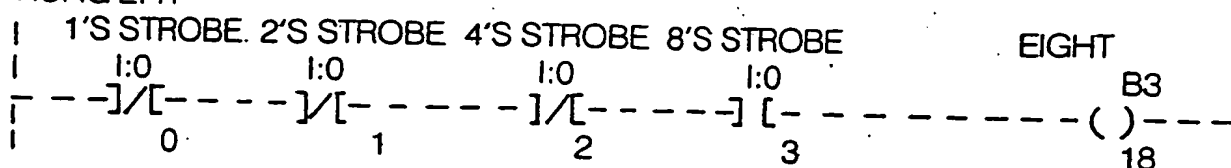


FIG. 16K

1'S STROBE 2'S STROBE 4'S STROBE 8'S STROBE NINE B3

1 0 1 2 3 () 19

RUNG 2:43

OP	OPN	OPND	OPND2	OPND3	OPND4	OPND5	OPND6	OPND7	OPND8	OPND9	OPND10	OPND11	OPND12	OPND13	OPND14	OPND15	OPND16	OPND17	OPND18	OPND19	OPND20	OPND21	OPND22	OPND23	OPND24	OPND25	OPND26	OPND27	OPND28	OPND29	OPND30	OPND31	OPND32	OPND33	OPND34	OPND35	OPND36	OPND37	OPND38	OPND39	OPND40	OPND41	OPND42	OPND43	OPND44	OPND45	OPND46	OPND47	OPND48	OPND49	OPND50	OPND51	OPND52	OPND53	OPND54	OPND55	OPND56	OPND57	OPND58	OPND59	OPND60	OPND61	OPND62	OPND63	OPND64	OPND65	OPND66	OPND67	OPND68	OPND69	OPND70	OPND71	OPND72	OPND73	OPND74	OPND75	OPND76	OPND77	OPND78	OPND79	OPND80	OPND81	OPND82	OPND83	OPND84	OPND85	OPND86	OPND87	OPND88	OPND89	OPND90	OPND91	OPND92	OPND93	OPND94	OPND95	OPND96	OPND97	OPND98	OPND99	OPND100	OPND101	OPND102	OPND103	OPND104	OPND105	OPND106	OPND107	OPND108	OPND109	OPND110	OPND111	OPND112	OPND113	OPND114	OPND115	OPND116	OPND117	OPND118	OPND119	OPND120	OPND121	OPND122	OPND123	OPND124	OPND125	OPND126	OPND127	OPND128	OPND129	OPND130	OPND131	OPND132	OPND133	OPND134	OPND135	OPND136	OPND137	OPND138	OPND139	OPND140	OPND141	OPND142	OPND143	OPND144	OPND145	OPND146	OPND147	OPND148	OPND149	OPND150	OPND151	OPND152	OPND153	OPND154	OPND155	OPND156	OPND157	OPND158	OPND159	OPND160	OPND161	OPND162	OPND163	OPND164	OPND165	OPND166	OPND167	OPND168	OPND169	OPND170	OPND171	OPND172	OPND173	OPND174	OPND175	OPND176	OPND177	OPND178	OPND179	OPND180	OPND181	OPND182	OPND183	OPND184	OPND185	OPND186	OPND187	OPND188	OPND189	OPND190	OPND191	OPND192	OPND193	OPND194	OPND195	OPND196	OPND197	OPND198	OPND199	OPND200	OPND201	OPND202	OPND203	OPND204	OPND205	OPND206	OPND207	OPND208	OPND209	OPND210	OPND211	OPND212	OPND213	OPND214	OPND215	OPND216	OPND217	OPND218	OPND219	OPND220	OPND221	OPND222	OPND223	OPND224	OPND225	OPND226	OPND227	OPND228	OPND229	OPND230	OPND231	OPND232	OPND233	OPND234	OPND235	OPND236	OPND237	OPND238	OPND239	OPND240	OPND241	OPND242	OPND243	OPND244	OPND245	OPND246	OPND247	OPND248	OPND249	OPND250	OPND251	OPND252	OPND253	OPND254	OPND255	OPND256	OPND257	OPND258	OPND259	OPND260	OPND261	OPND262	OPND263	OPND264	OPND265	OPND266	OPND267	OPND268	OPND269	OPND270	OPND271	OPND272	OPND273	OPND274	OPND275	OPND276	OPND277	OPND278	OPND279	OPND280	OPND281	OPND282	OPND283	OPND284	OPND285	OPND286	OPND287	OPND288	OPND289	OPND290	OPND291	OPND292	OPND293	OPND294	OPND295	OPND296	OPND297	OPND298	OPND299	OPND300	OPND301	OPND302	OPND303	OPND304	OPND305	OPND306	OPND307	OPND308	OPND309	OPND310	OPND311	OPND312	OPND313	OPND314	OPND315	OPND316	OPND317	OPND318	OPND319	OPND320	OPND321	OPND322	OPND323	OPND324	OPND325	OPND326	OPND327	OPND328	OPND329	OPND330	OPND331	OPND332	OPND333	OPND334	OPND335	OPND336	OPND337	OPND338	OPND339	OPND340	OPND341	OPND342	OPND343	OPND344	OPND345	OPND346	OPND347	OPND348	OPND349	OPND350	OPND351	OPND352	OPND353	OPND354	OPND355	OPND356	OPND357	OPND358	OPND359	OPND360	OPND361	OPND362	OPND363	OPND364	OPND365	OPND366	OPND367	OPND368	OPND369	OPND370	OPND371	OPND372	OPND373	OPND374	OPND375	OPND376	OPND377	OPND378	OPND379	OPND380
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FIG. 16L

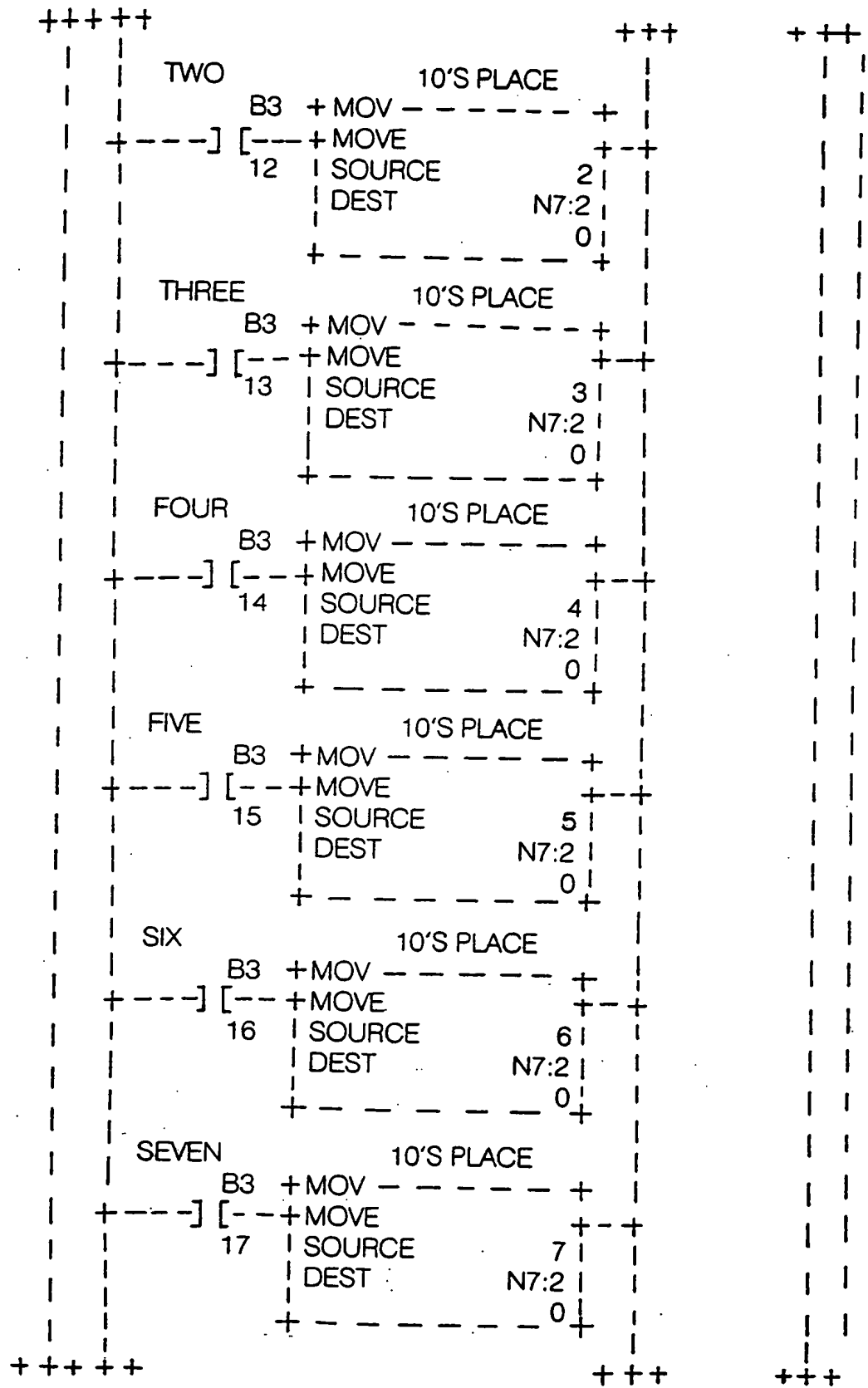


FIG. 16N

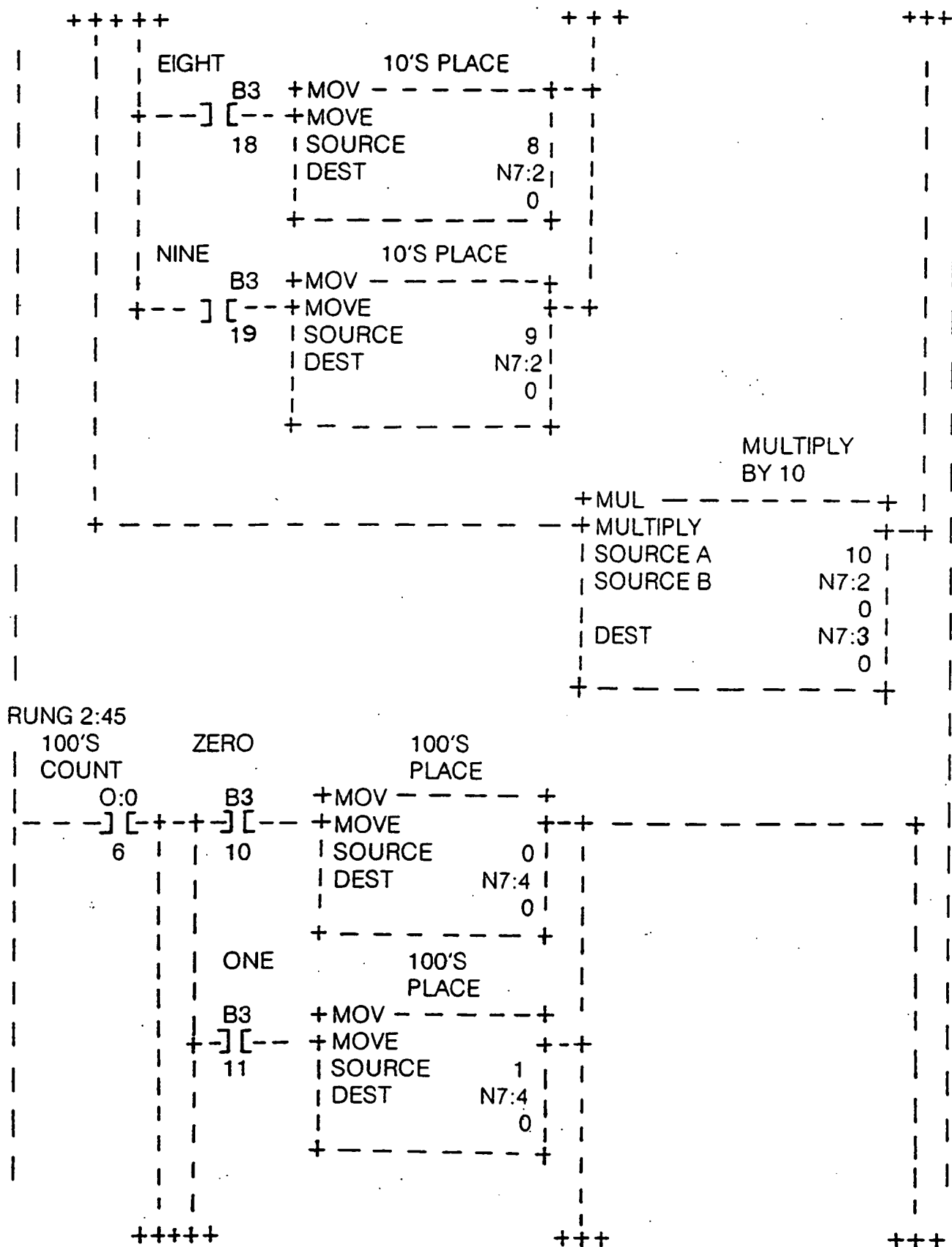
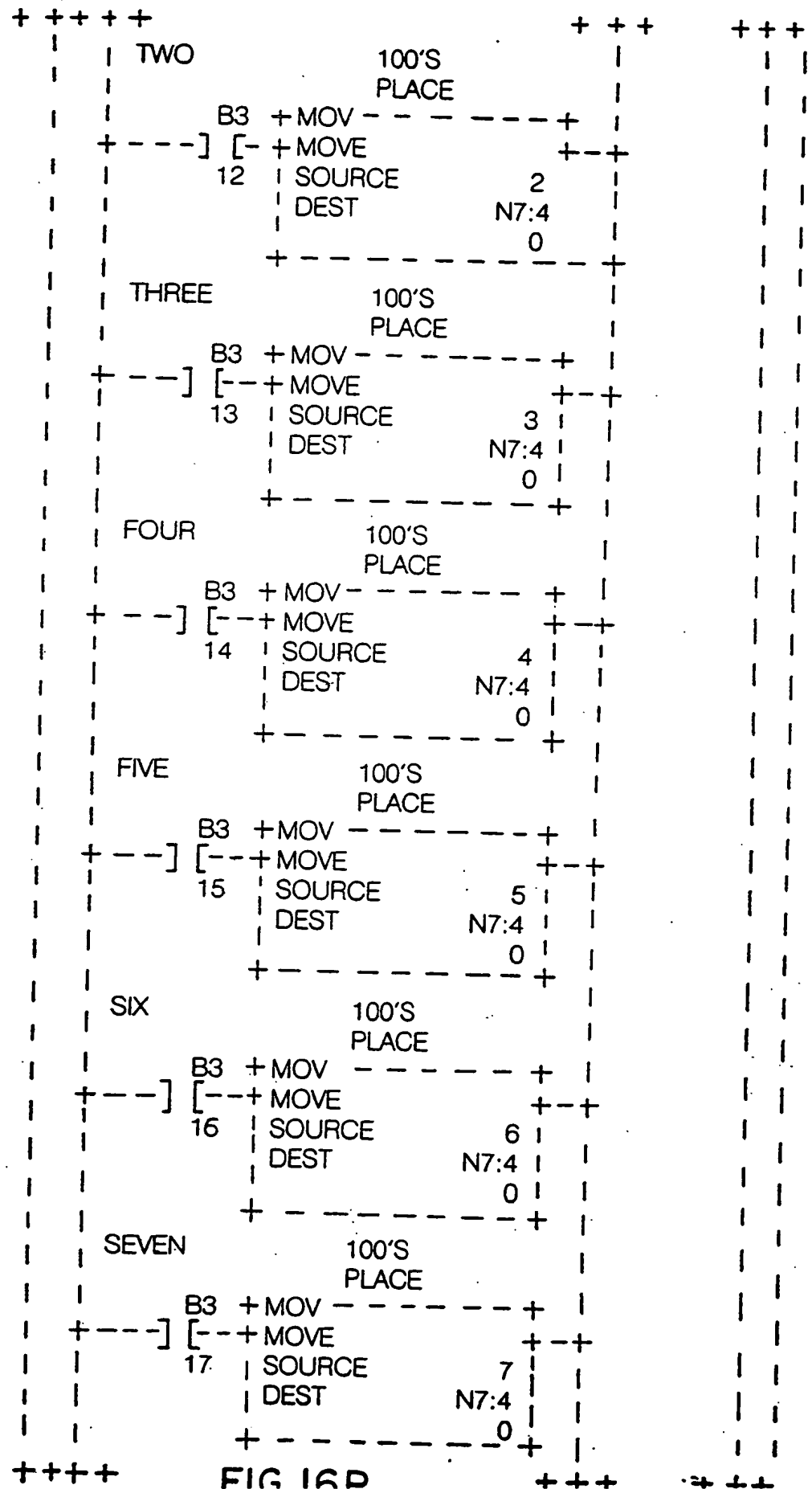


FIG.160



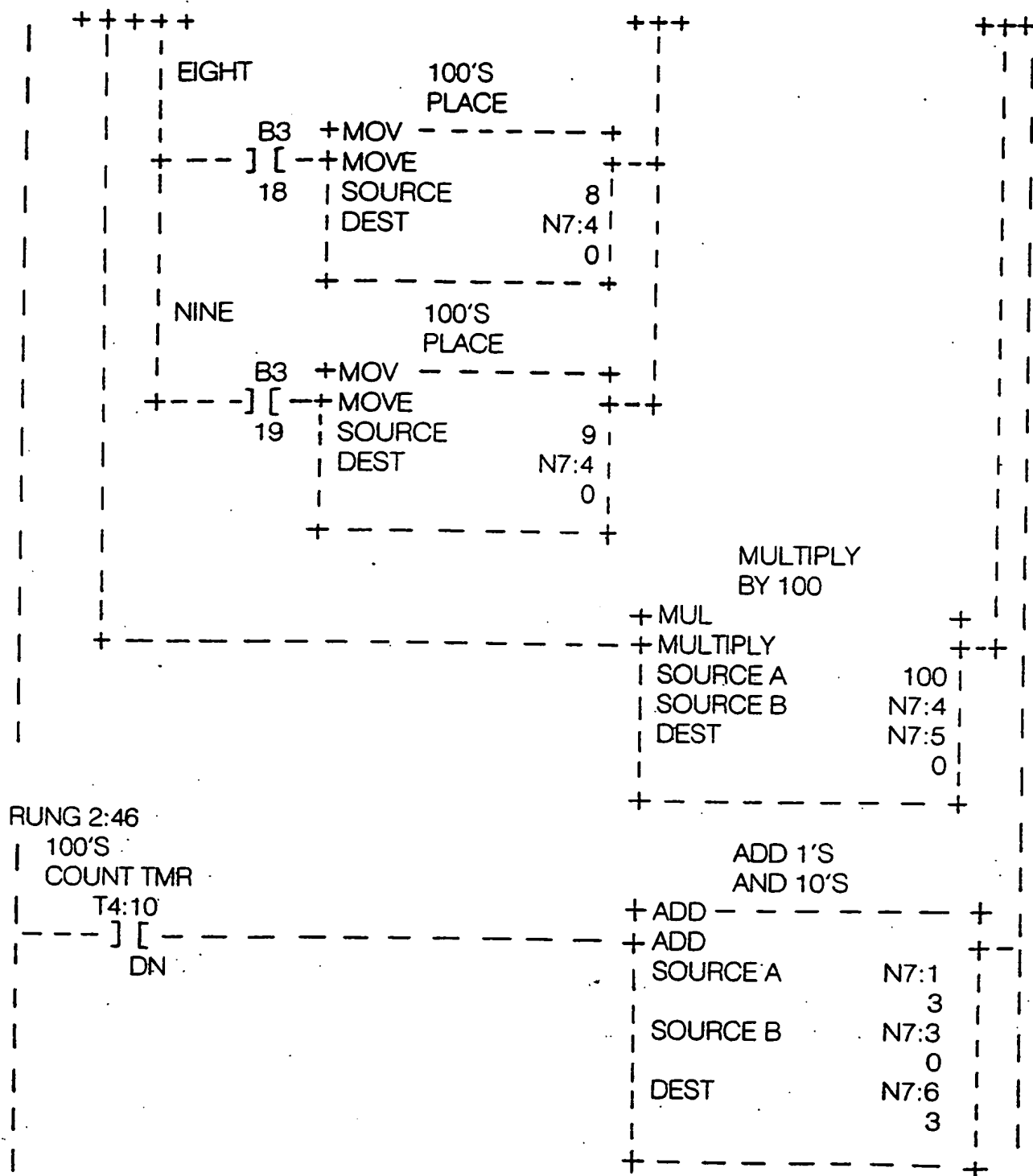


FIG. 16Q

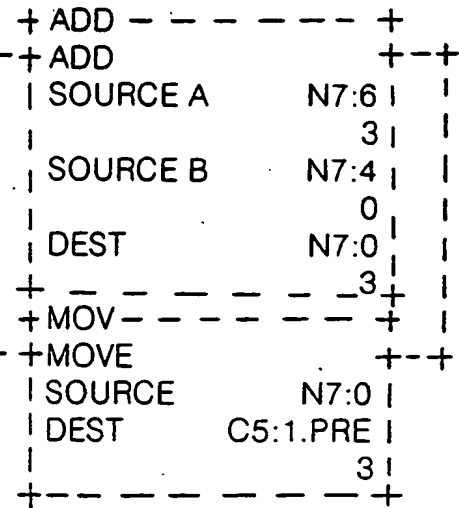
RUNG 2:47

100'S
COUNT TMR

T4:10

DN

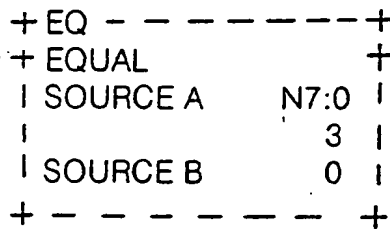
ADD TOTAL
TO 100'S



RUNGS 2:48 THRU 2:50 COUNTER CONTROLS.
THE COUNTER IS RESET EVERY TIME IT
REACHES IT'S COUNT, AND RELOADS THE
THUMBWHEEL VALUE. THIS HAPPENS ALSO
WHEN THE START BUTTON IS PRESSED.

RUNG 2:48

ADD TOTAL
TO 100'S



COUNT SET AT ZERO

B3

1

RUNG 2:49

COUNTER

C5:1

DN

START PB

I:0

11

COUNTER

C5:1

(RES)

RUNG 2:50

INDEX ROTARY SW COUNT SET CONV RUN COUNTER COUNTER

PHOTOCELL CONTINUOUS AT ZERO

ONE SHOT

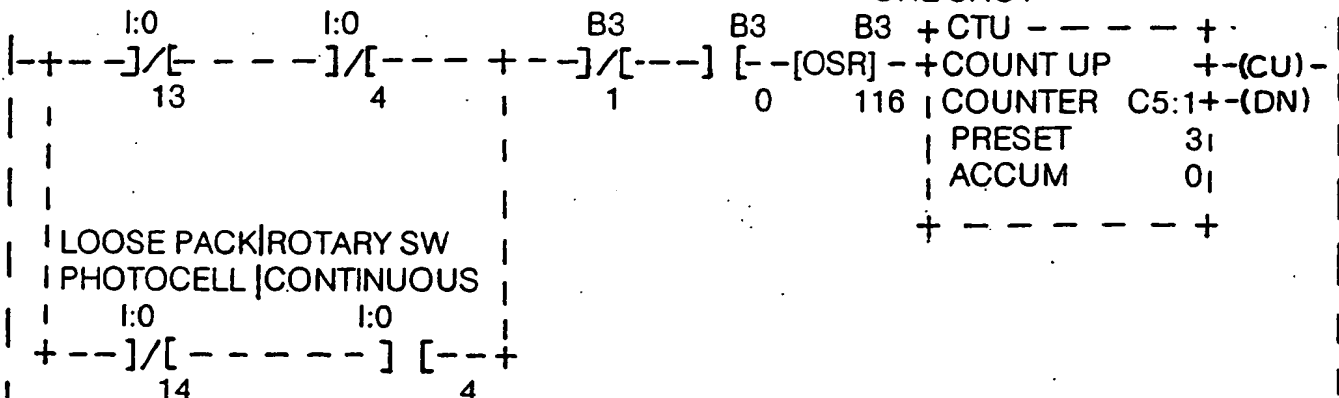
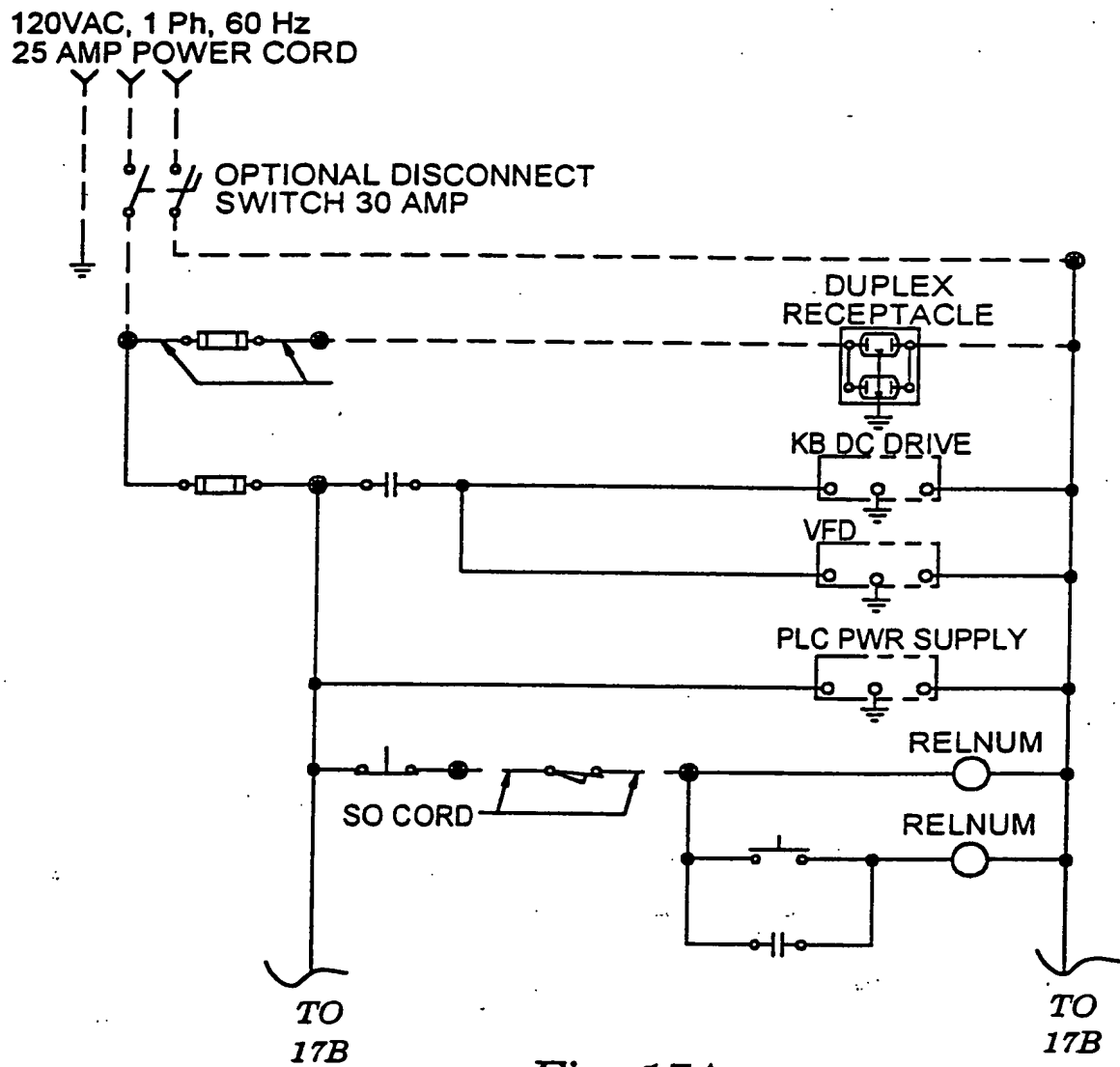


FIG.16R

RUNG 2:51





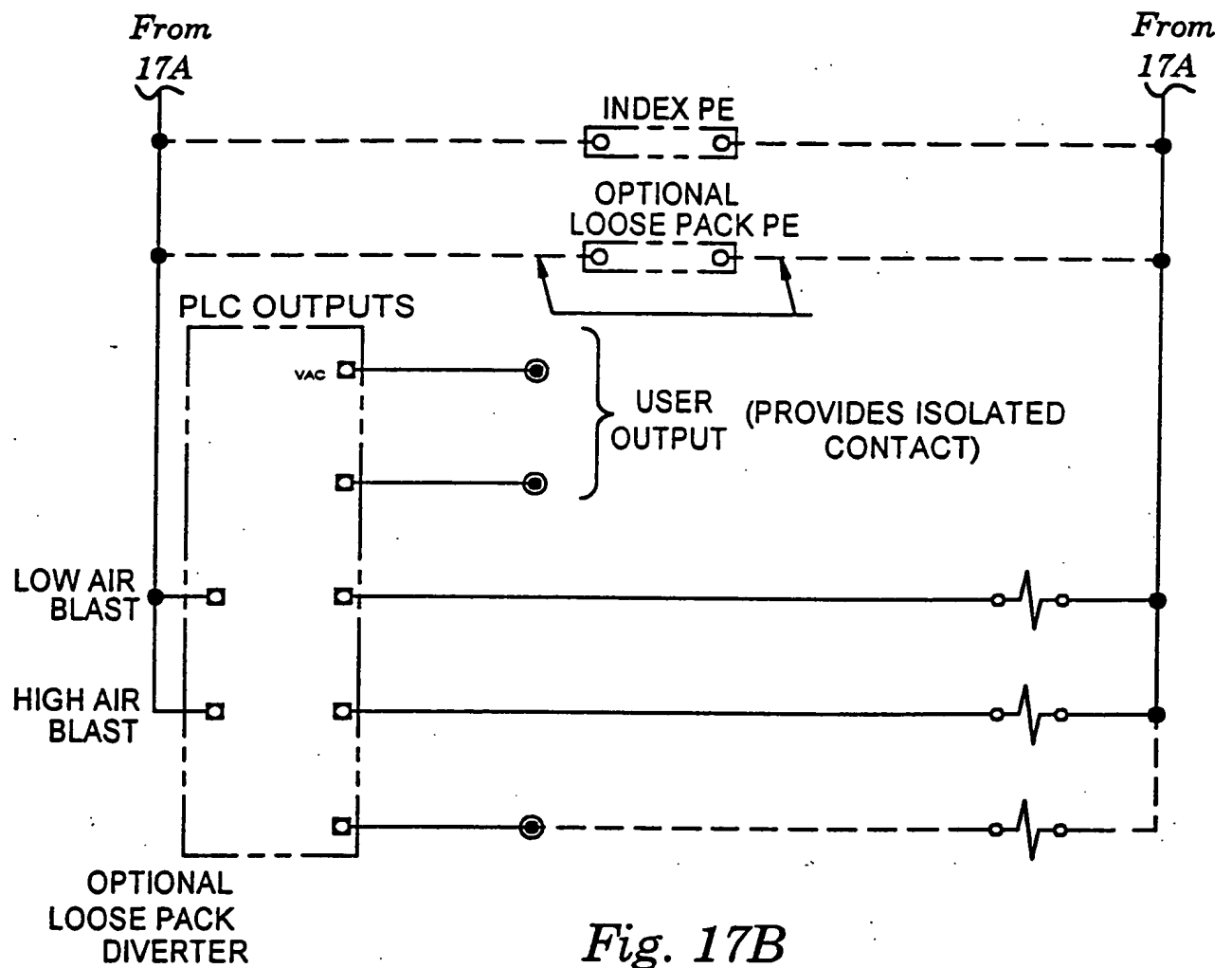
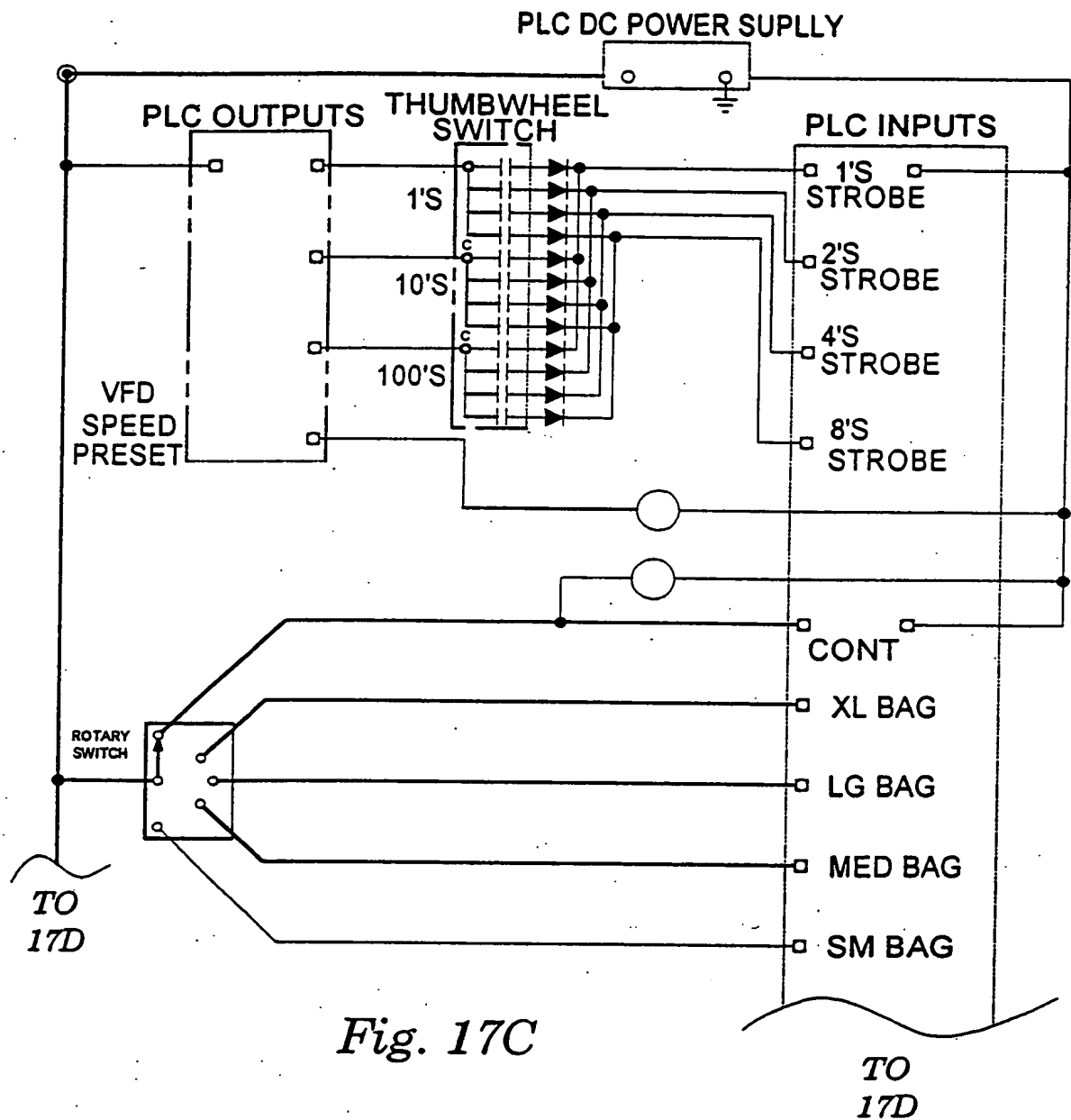


Fig. 17B



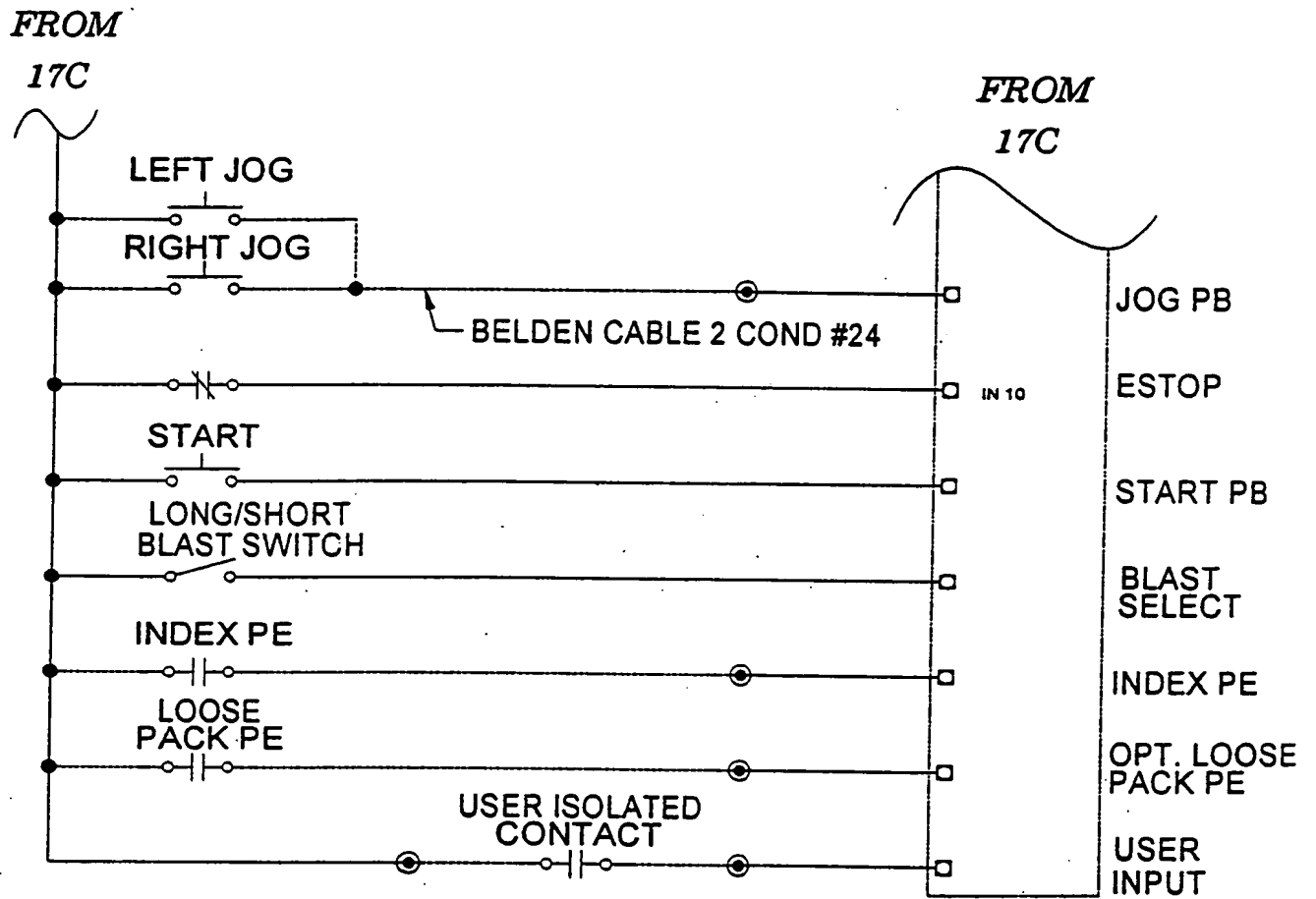


Fig. 17D

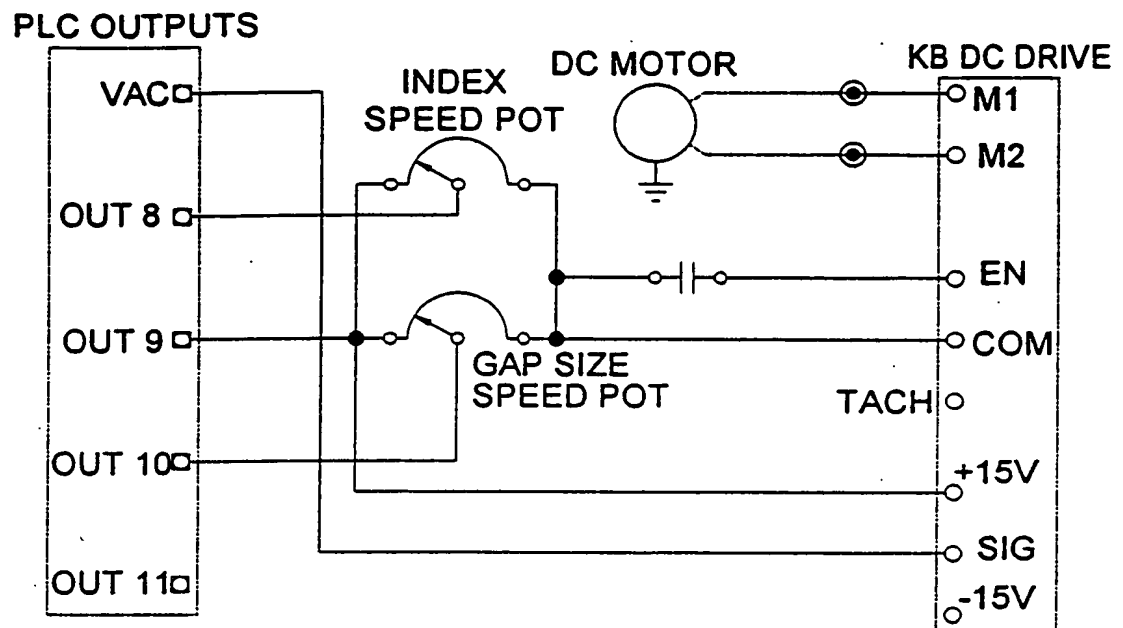


Fig. 17E

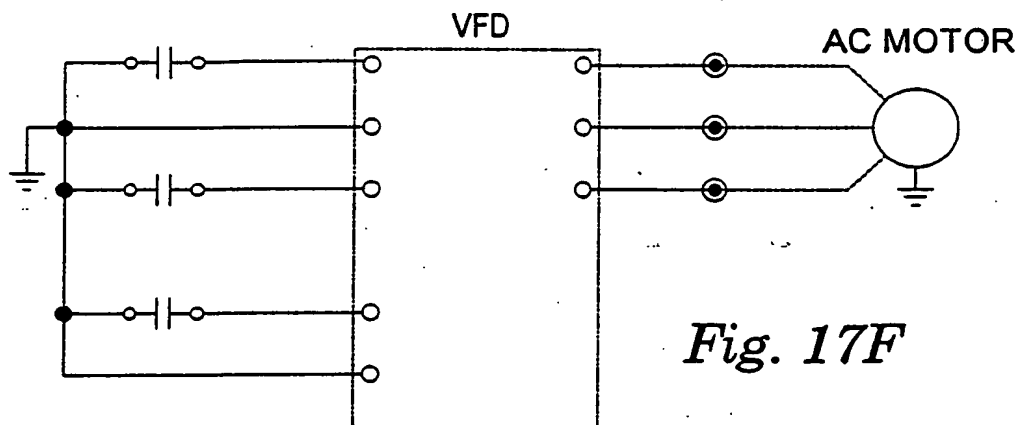
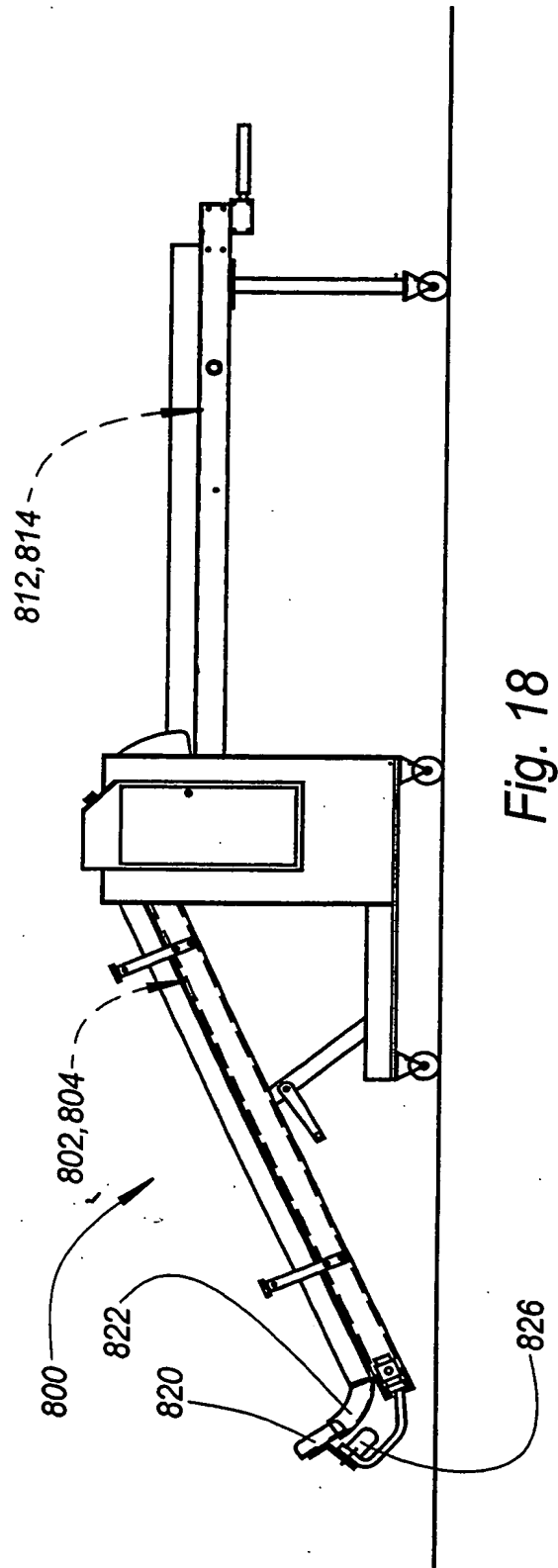
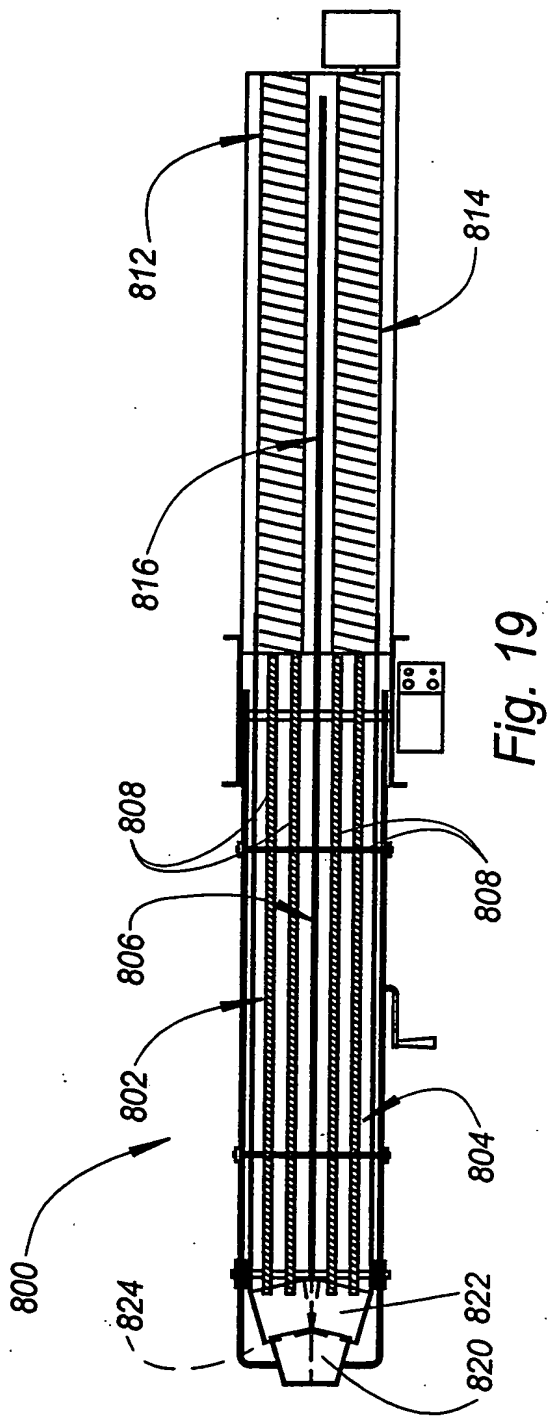
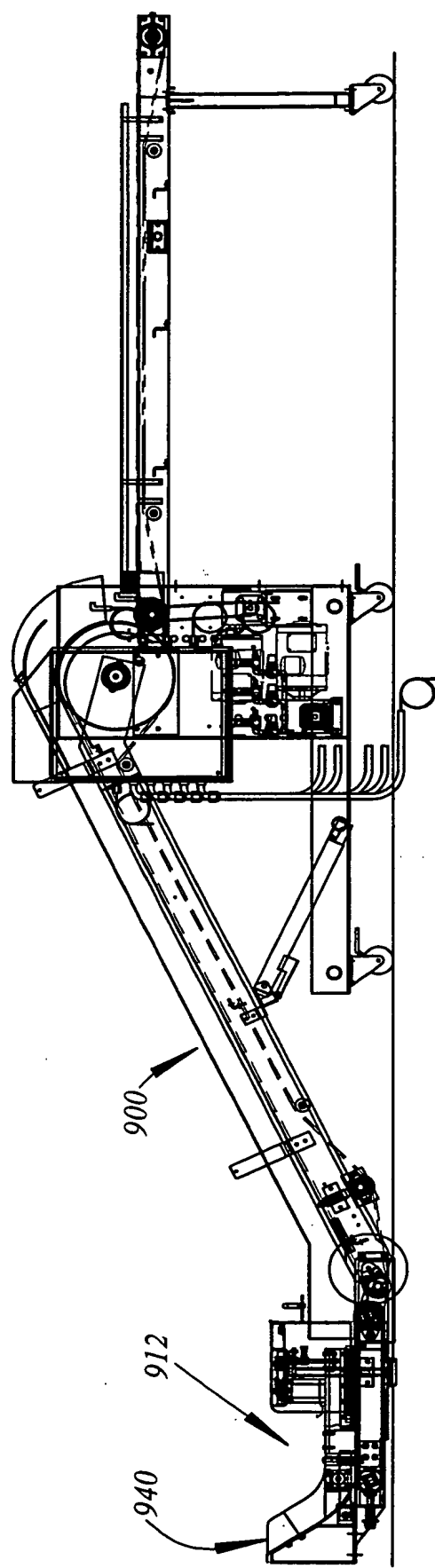
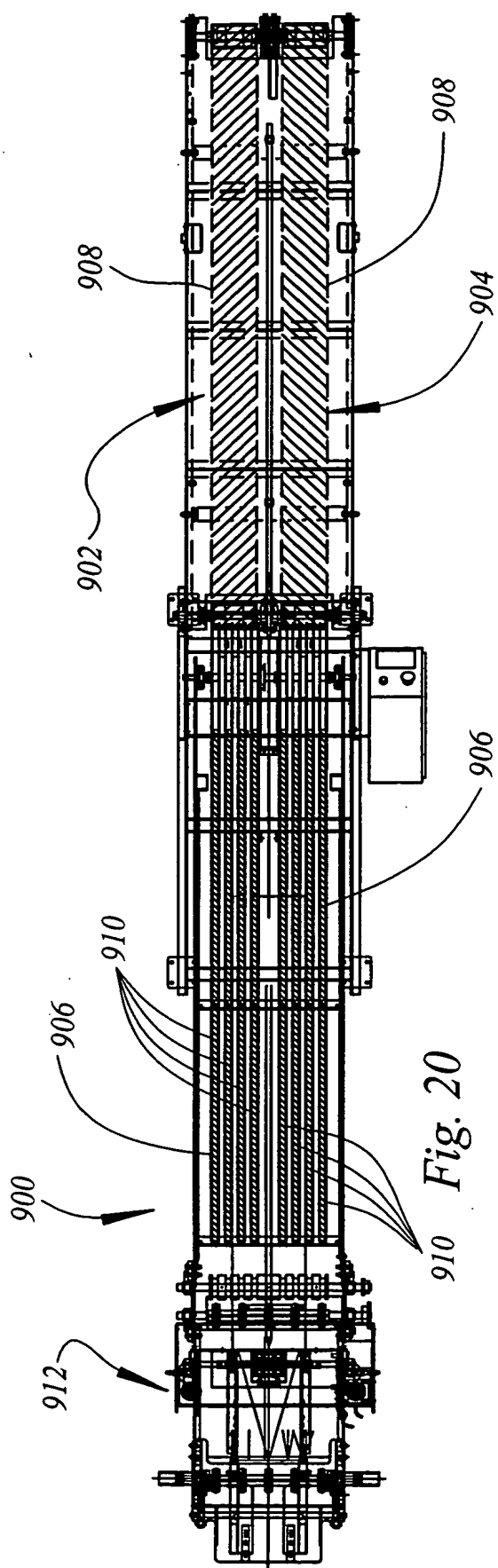


Fig. 17F





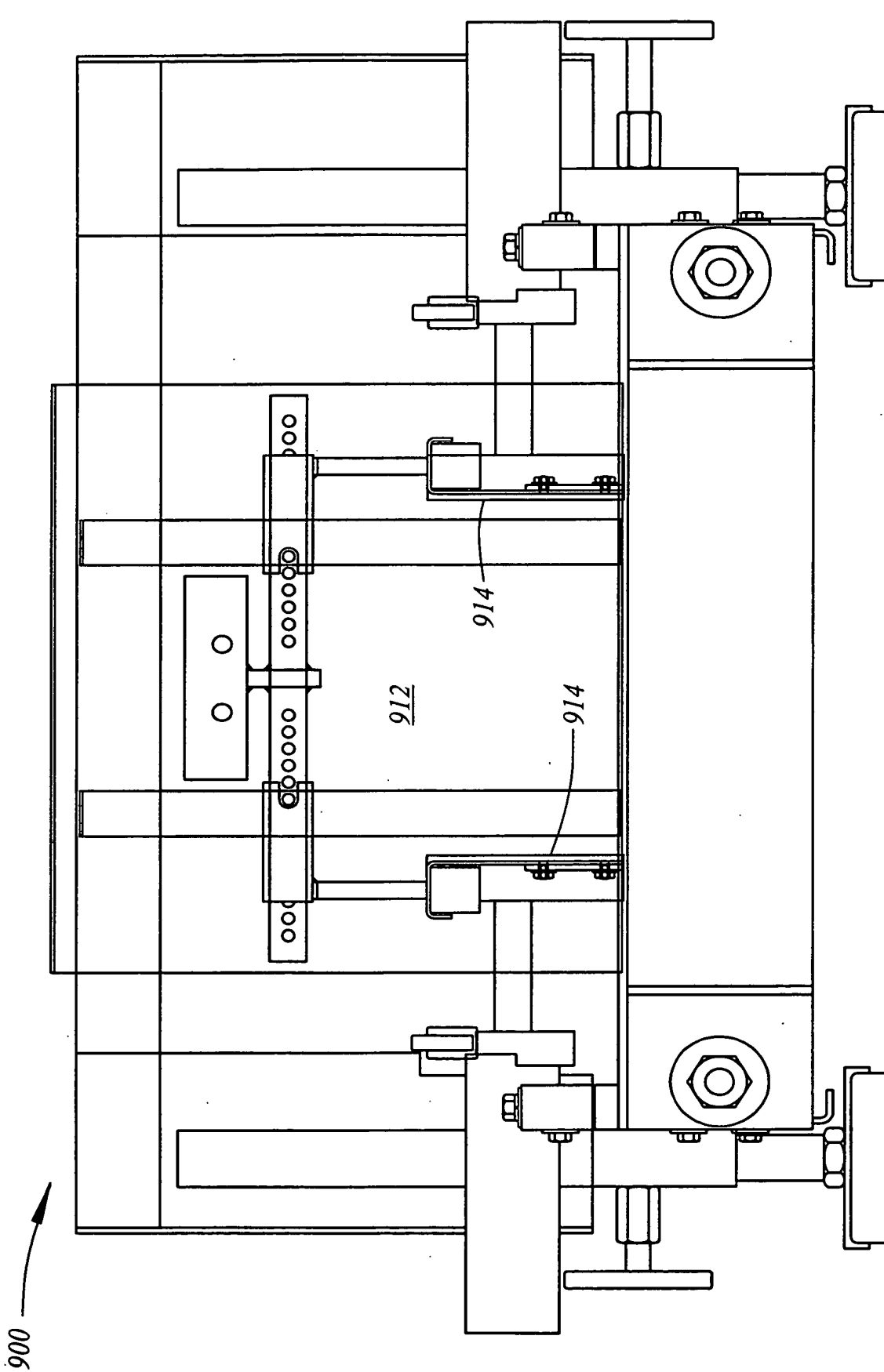


Fig. 22

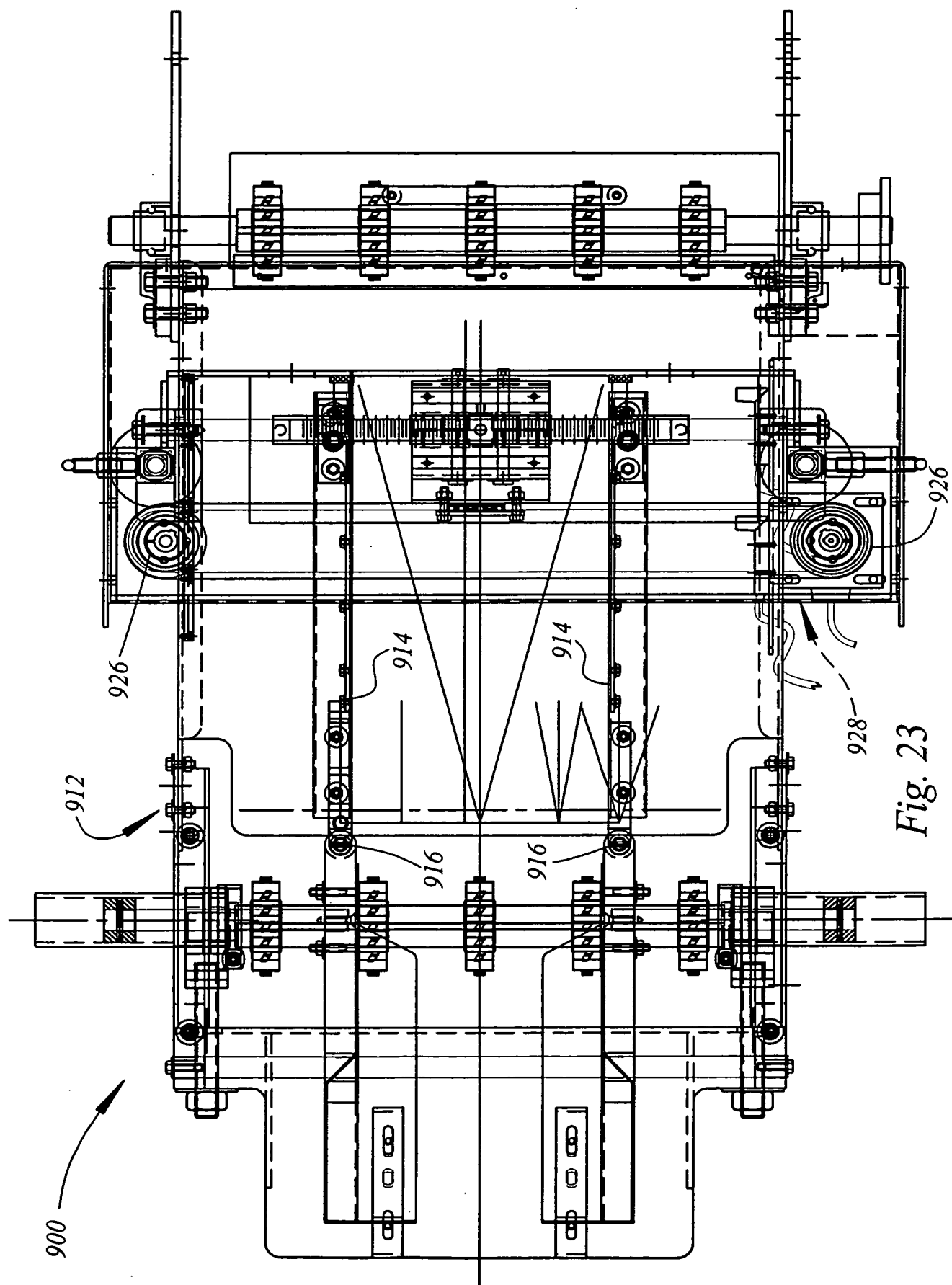


Fig. 23

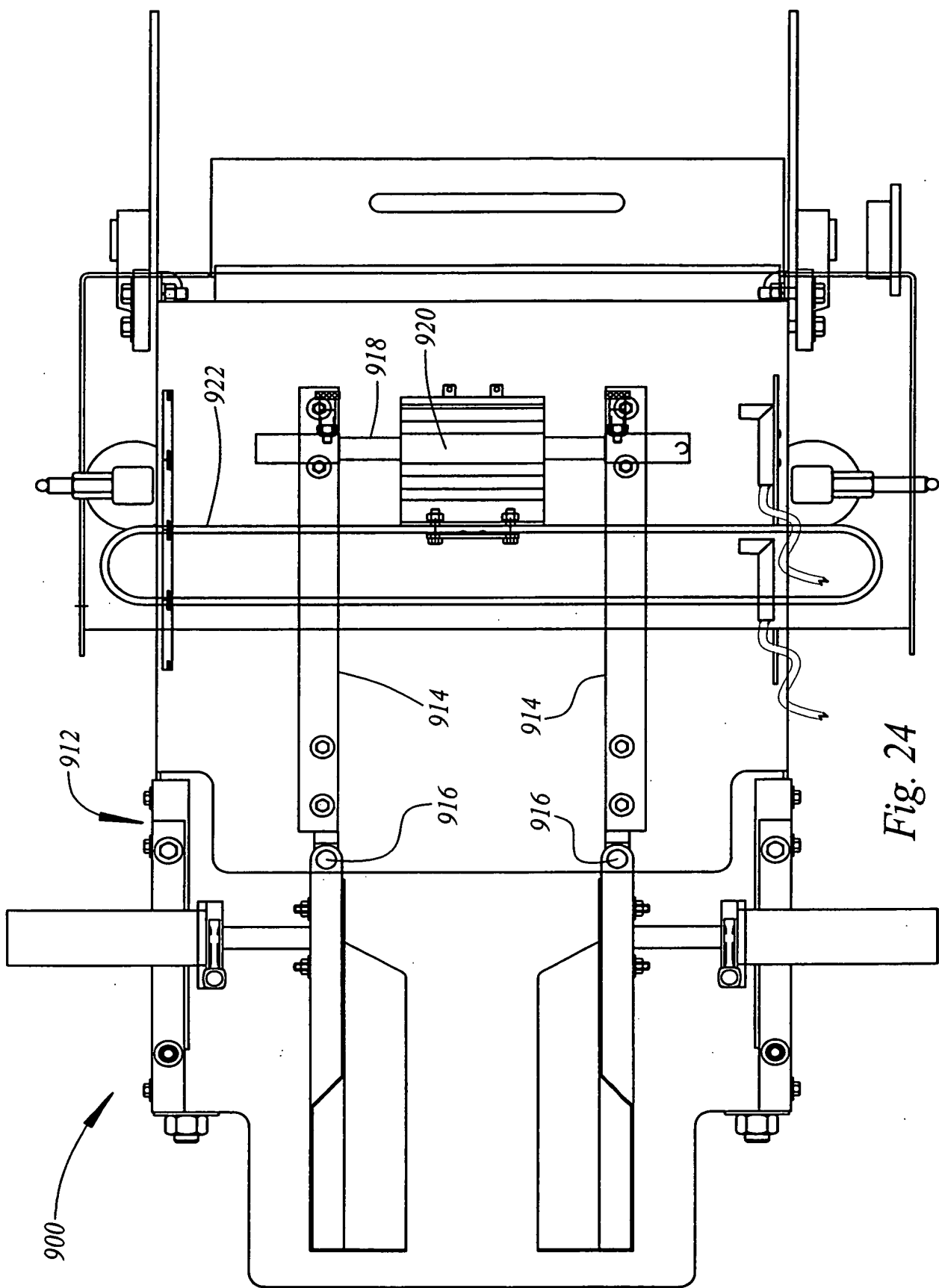


Fig. 24

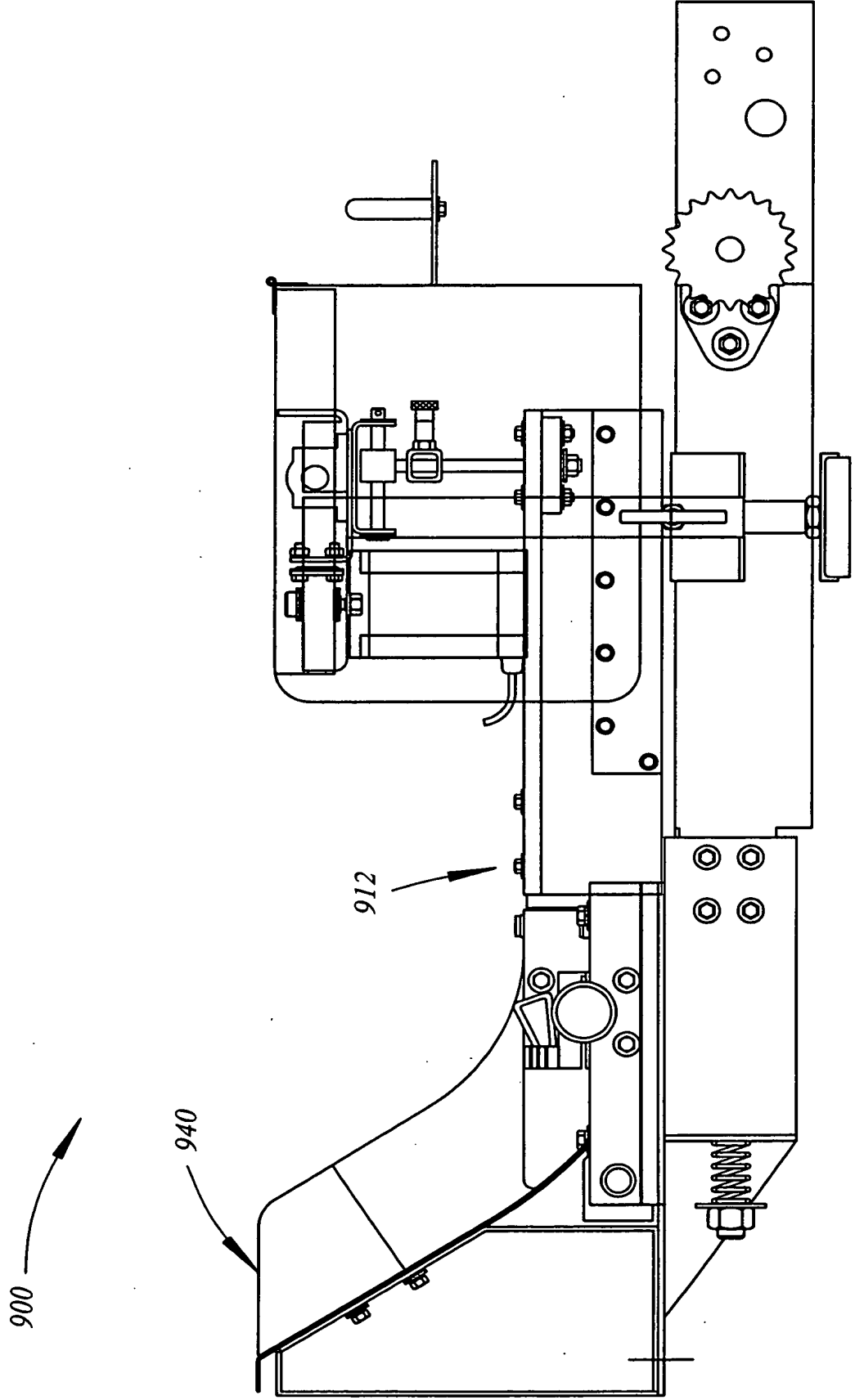


Fig. 25

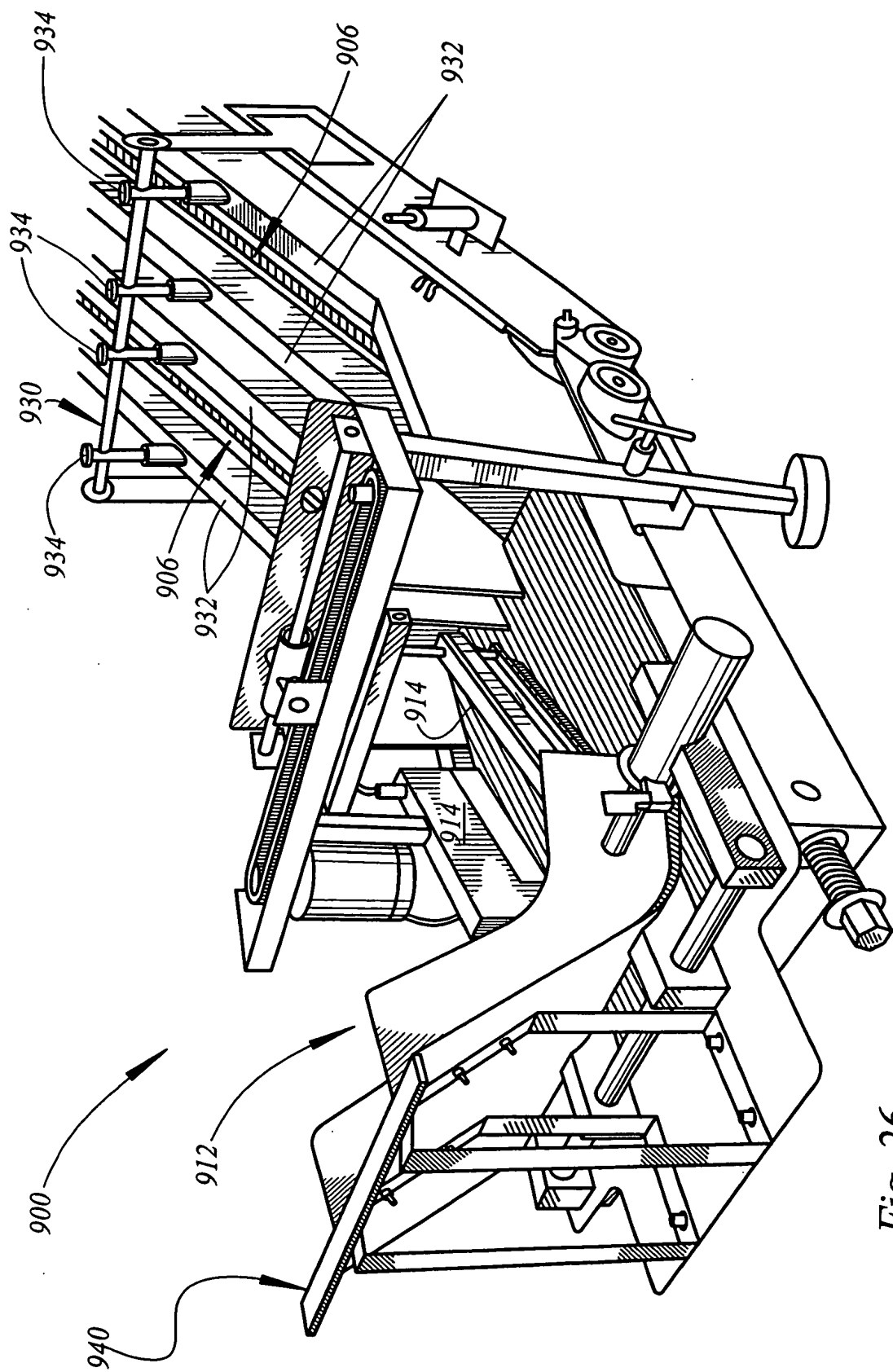


Fig. 26

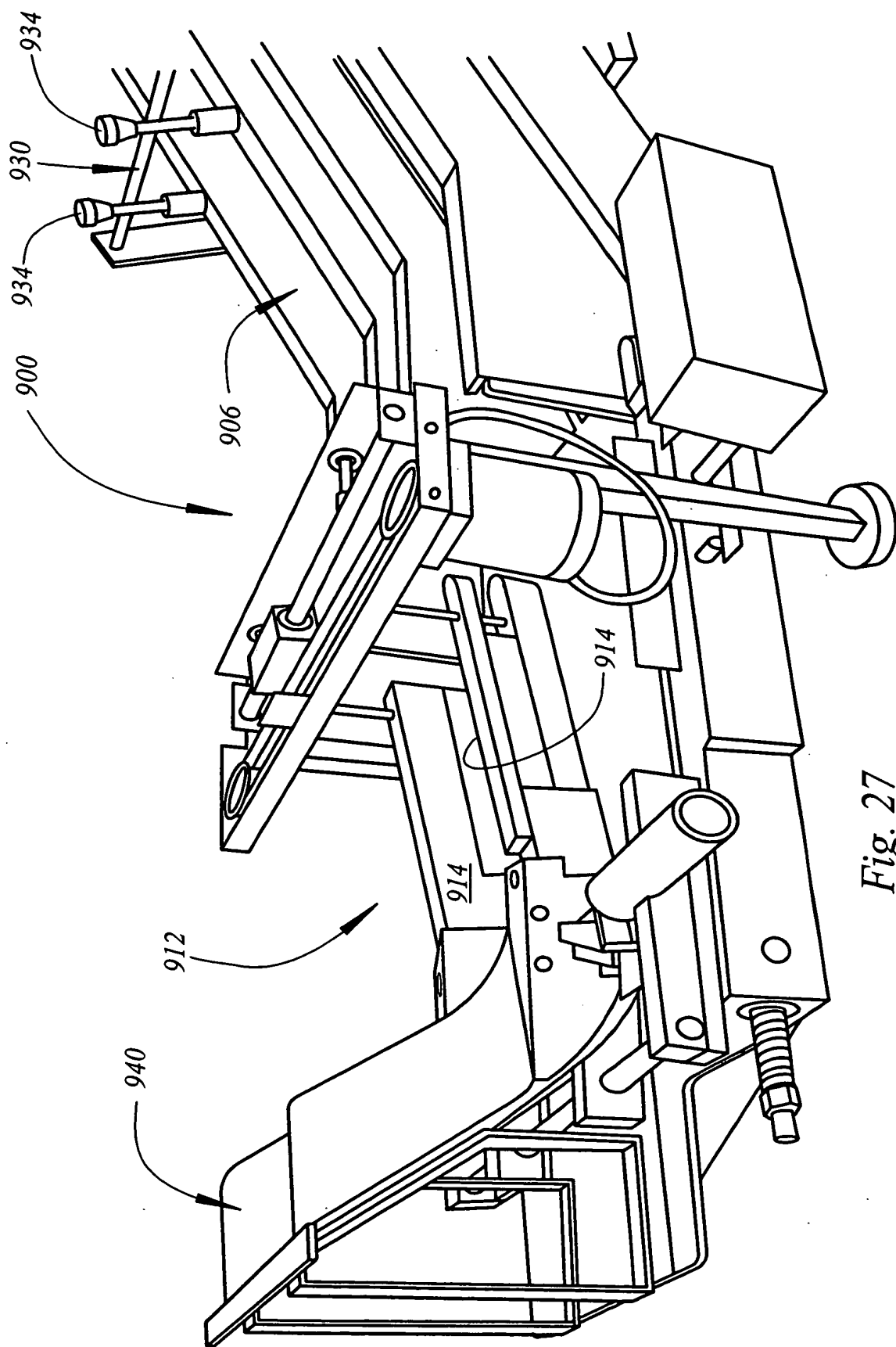


Fig. 27

